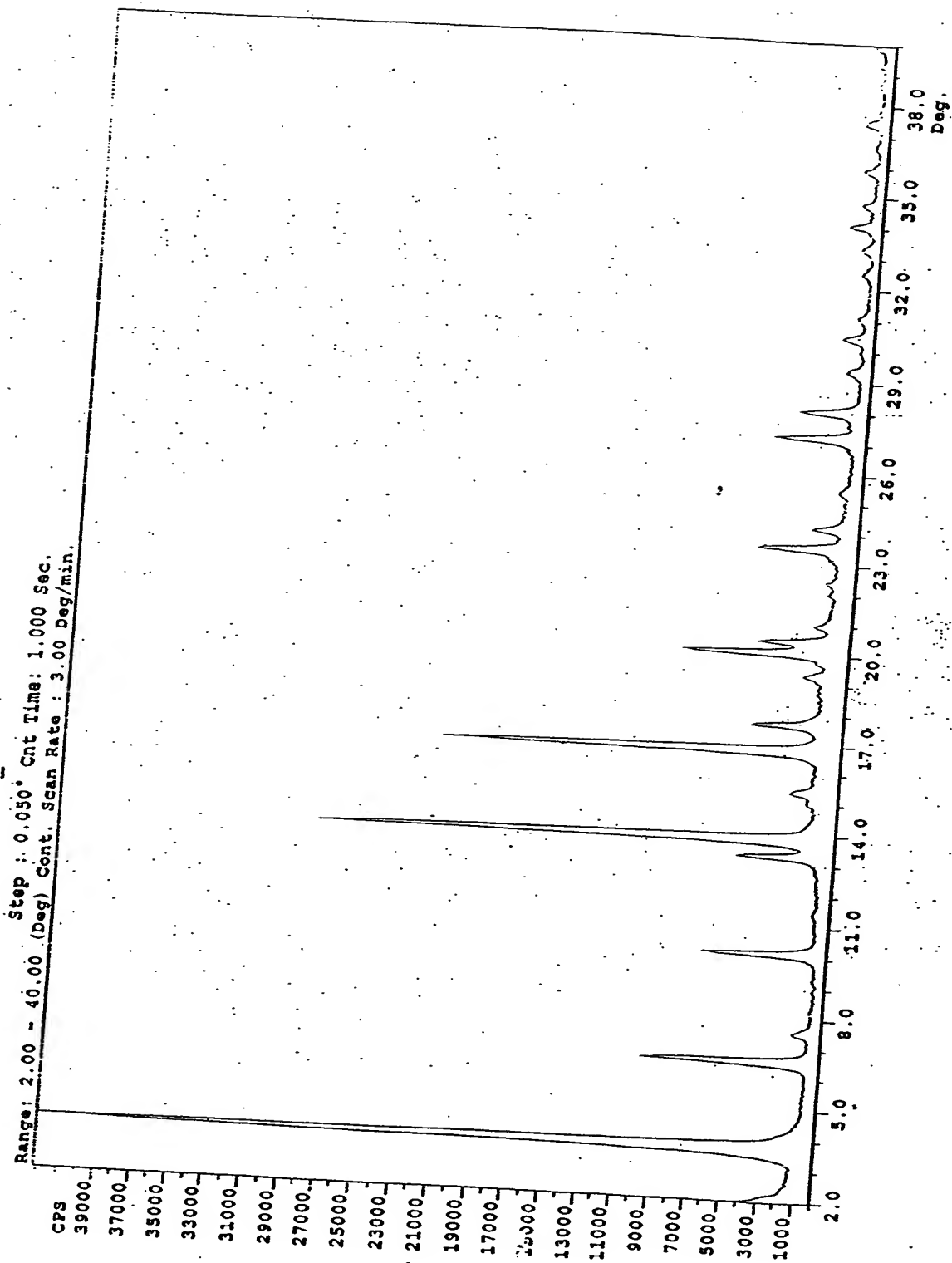


Fig 1

A



BEST AVAILABLE COPY

FIG. 2 C

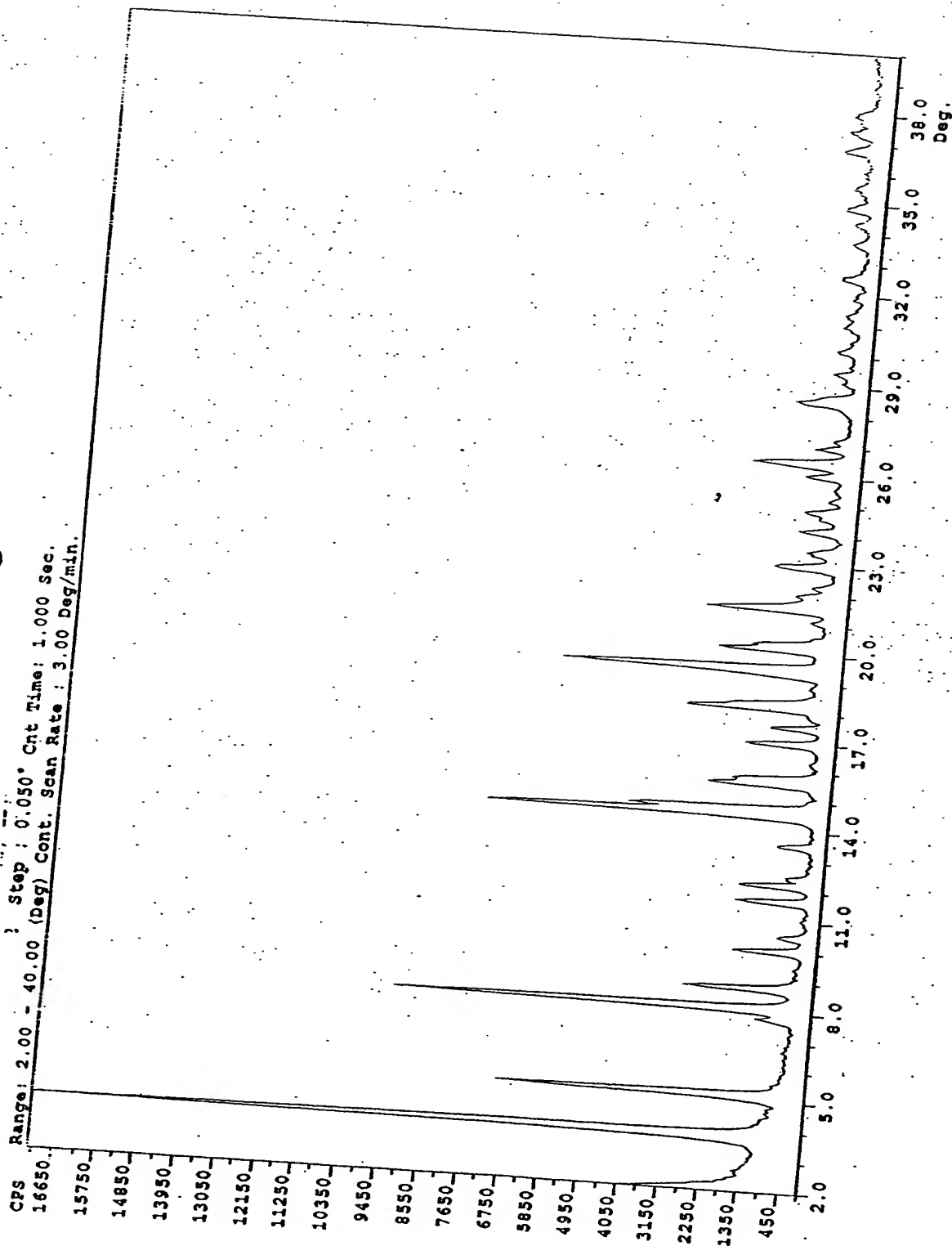


Fig 3 D

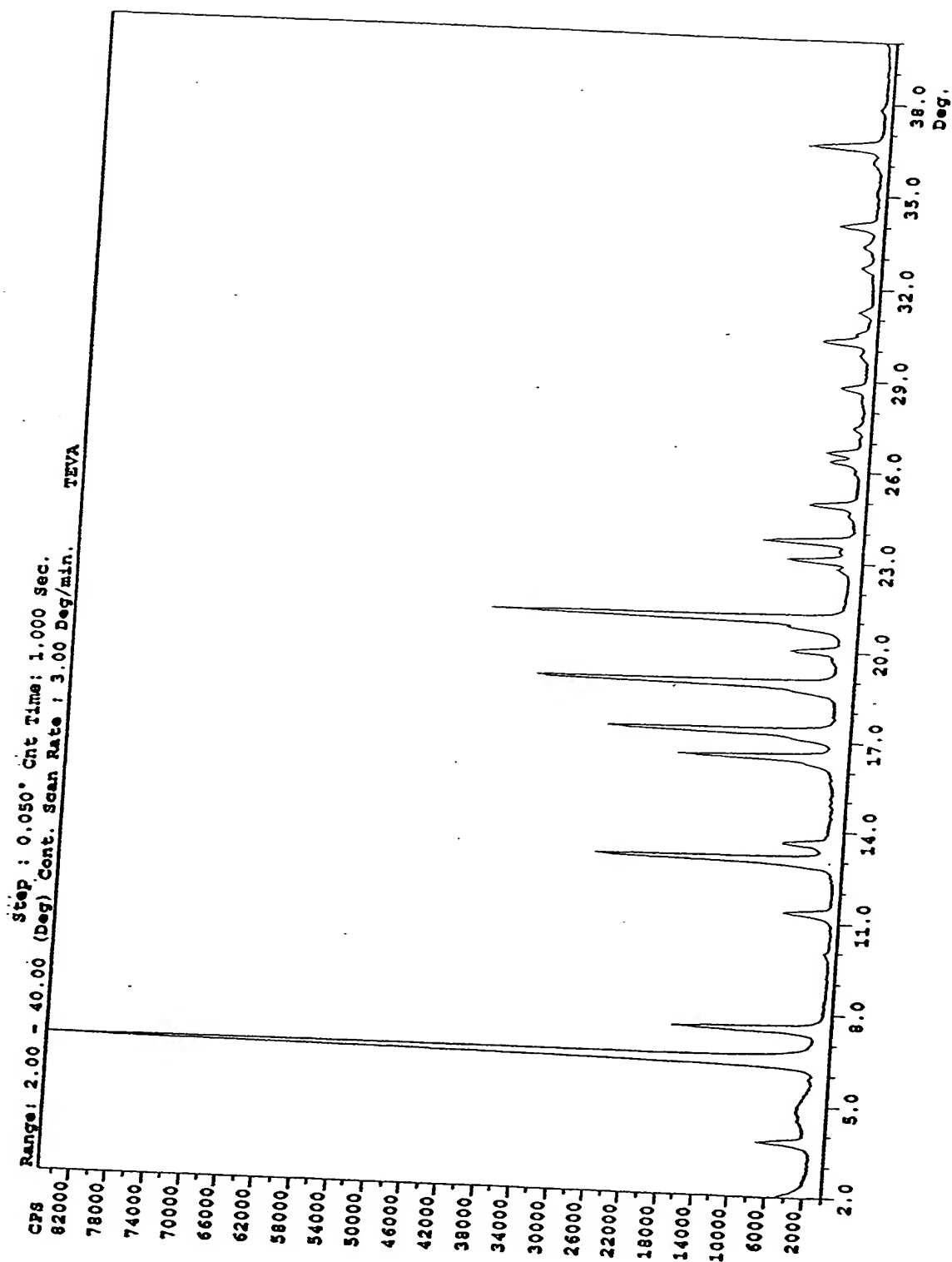


Fig 4 .E

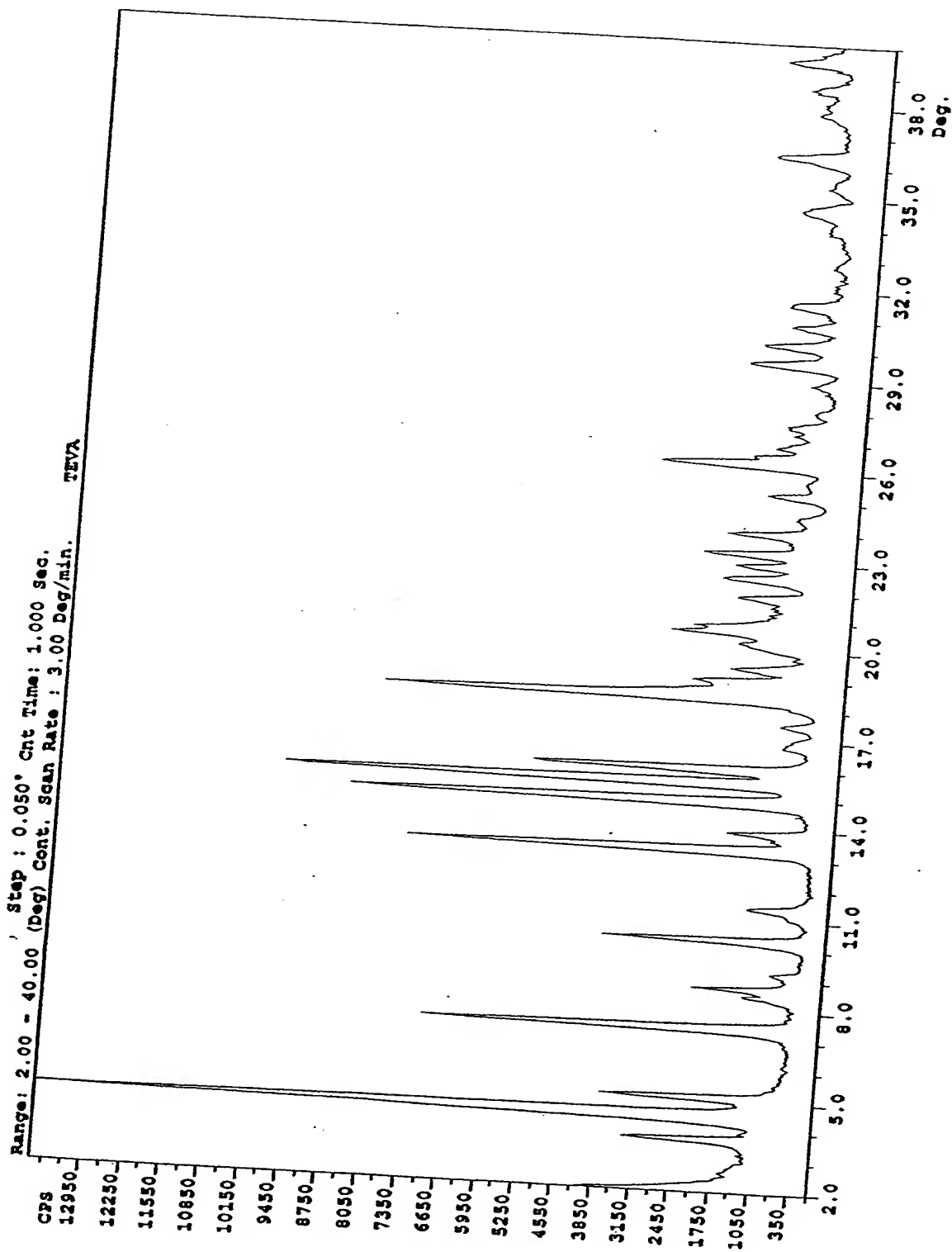


Fig. 5

F

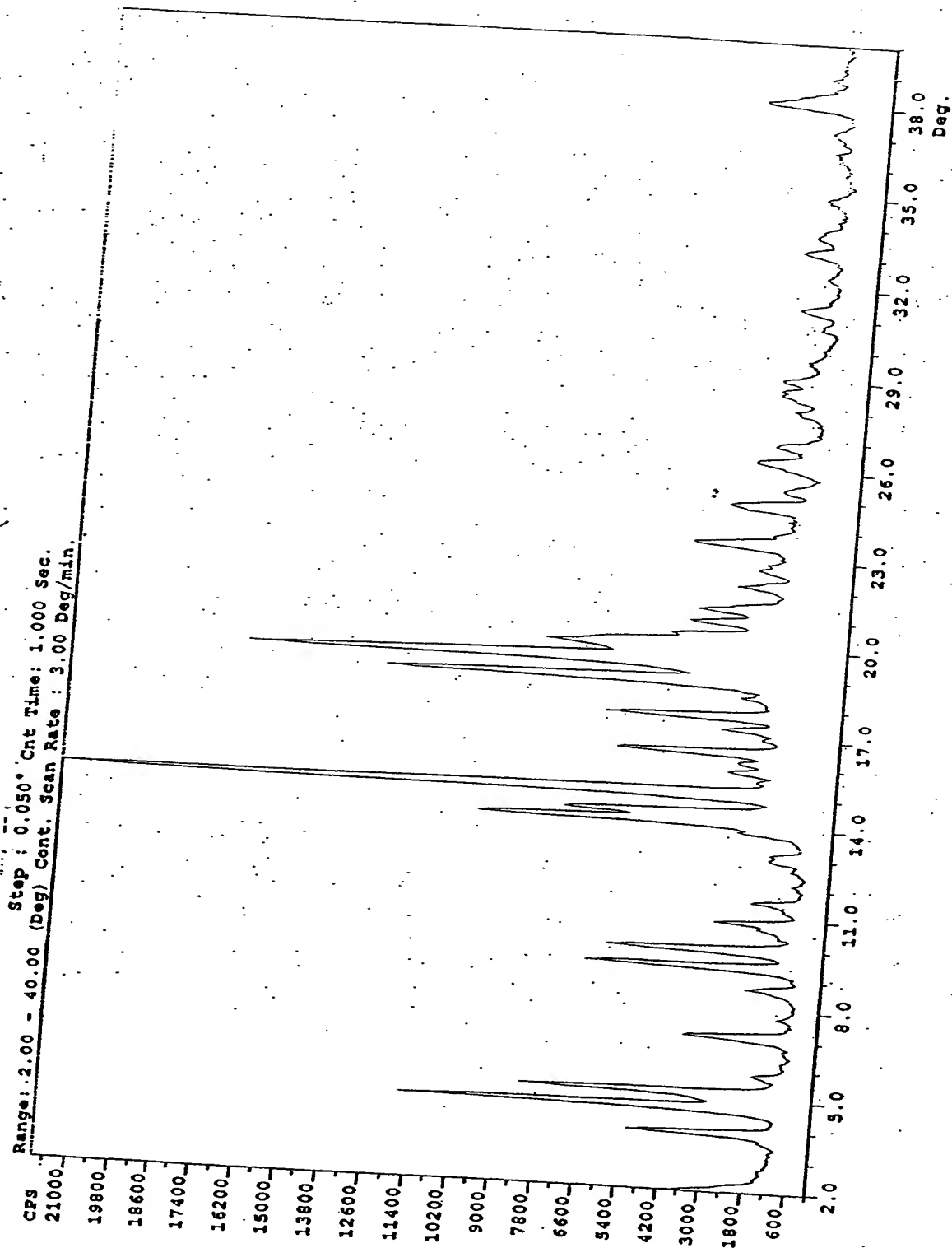


Fig. 6

G

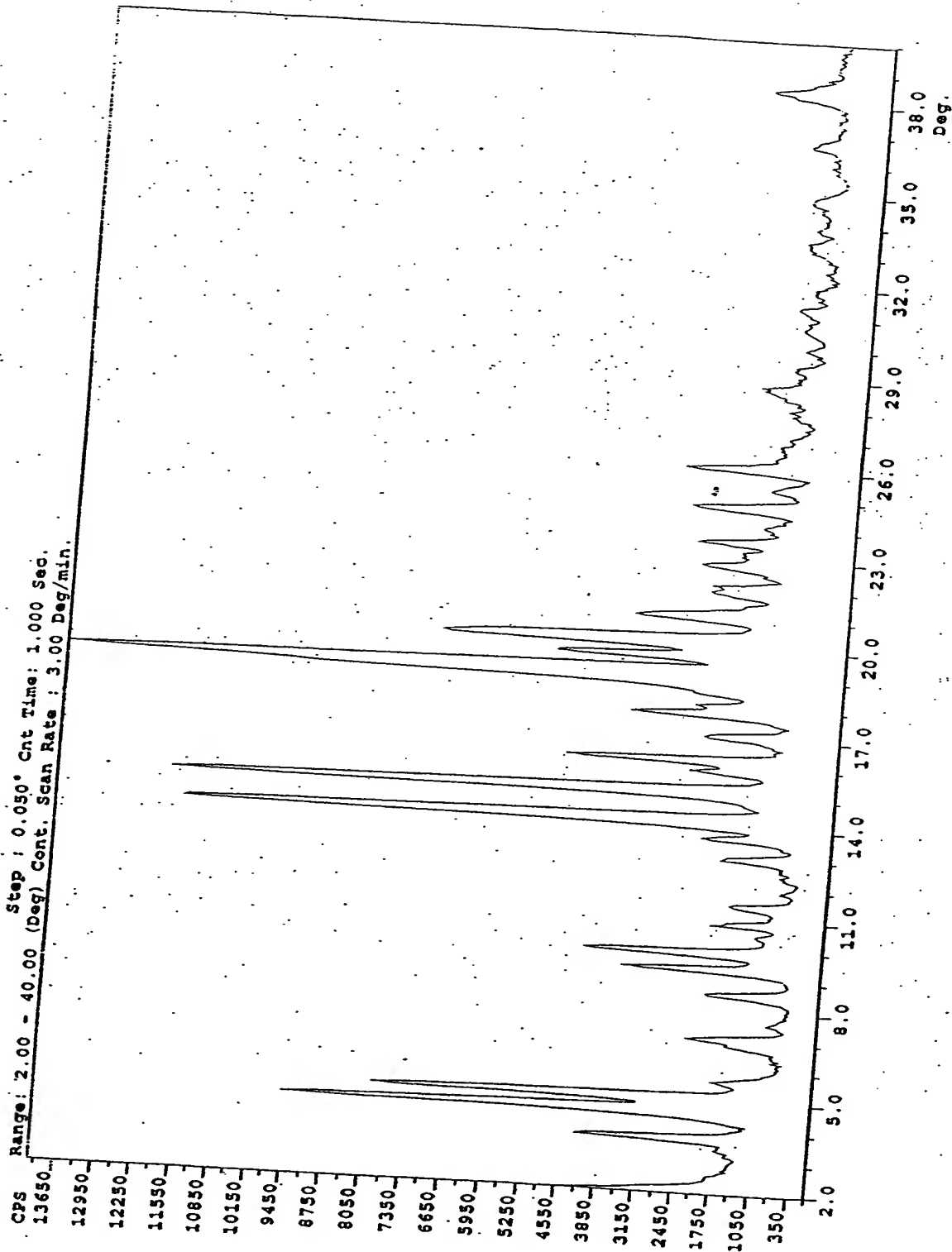


Fig 7 I

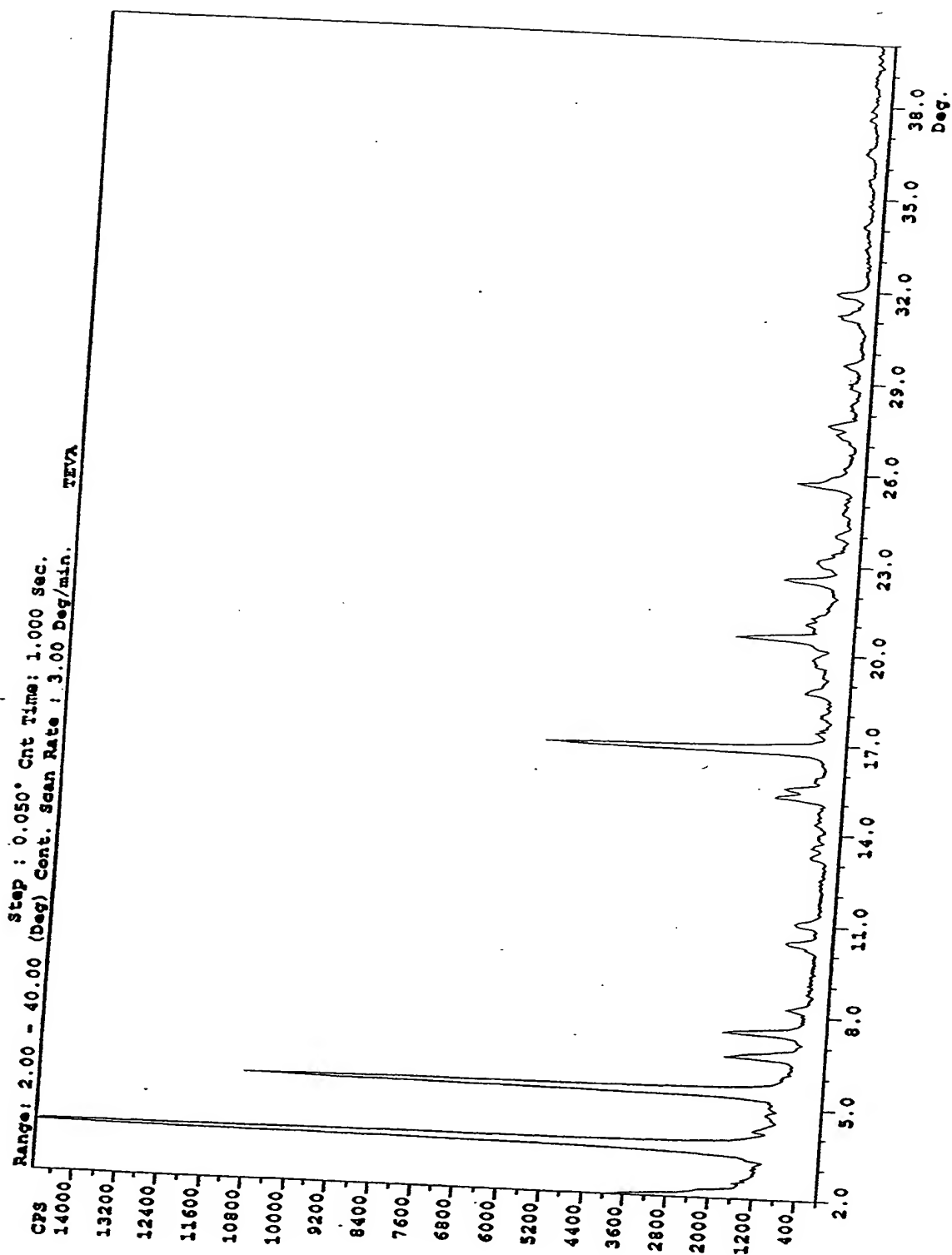


Fig. 8

Range: 2.00 - 40.00 (Deg) Step: 0.050° Cnt Time: 1.000 Sec.  
Cont. Scan Rate: 3.00 Deg/min.

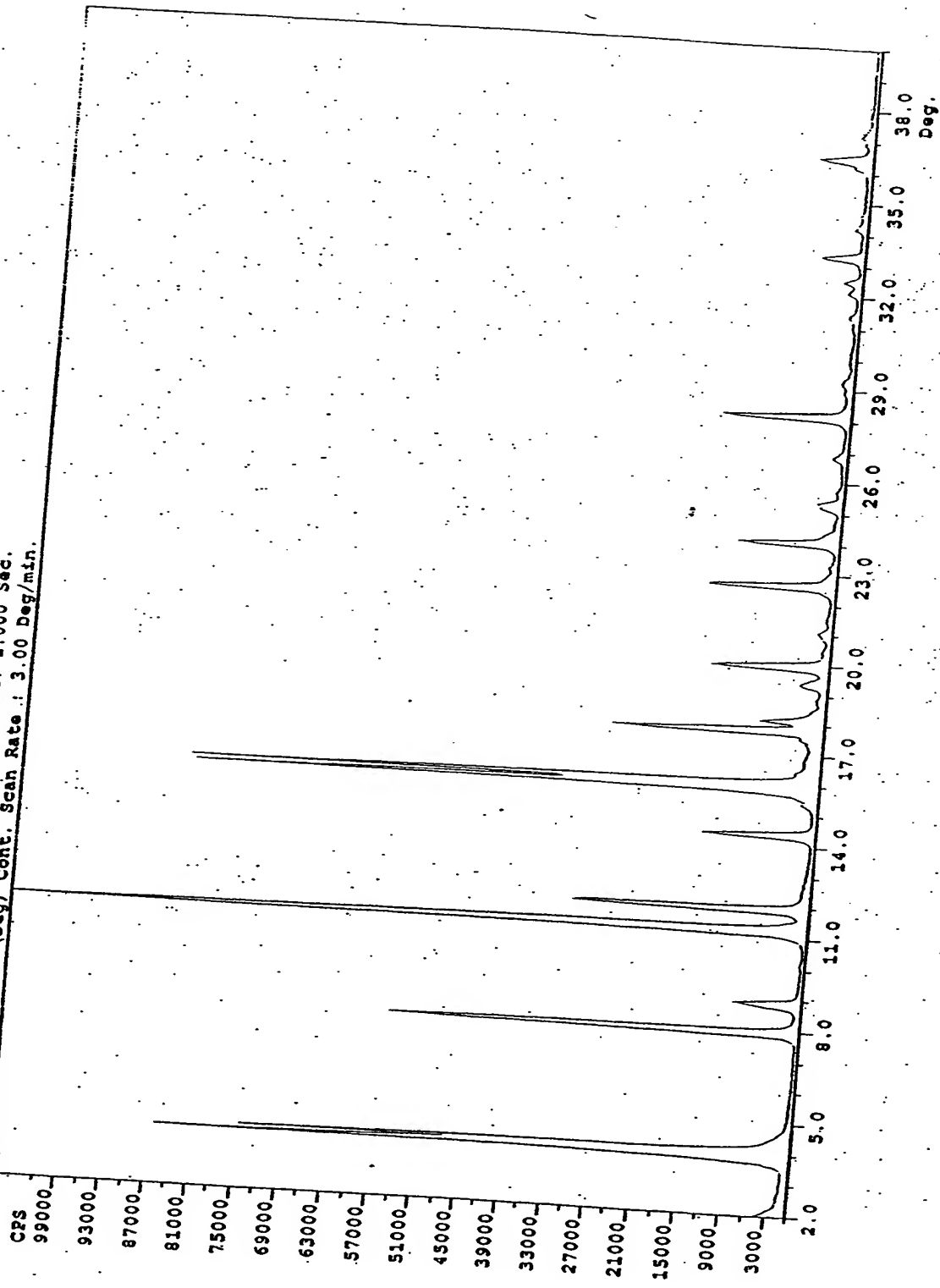




Fig. 9

K

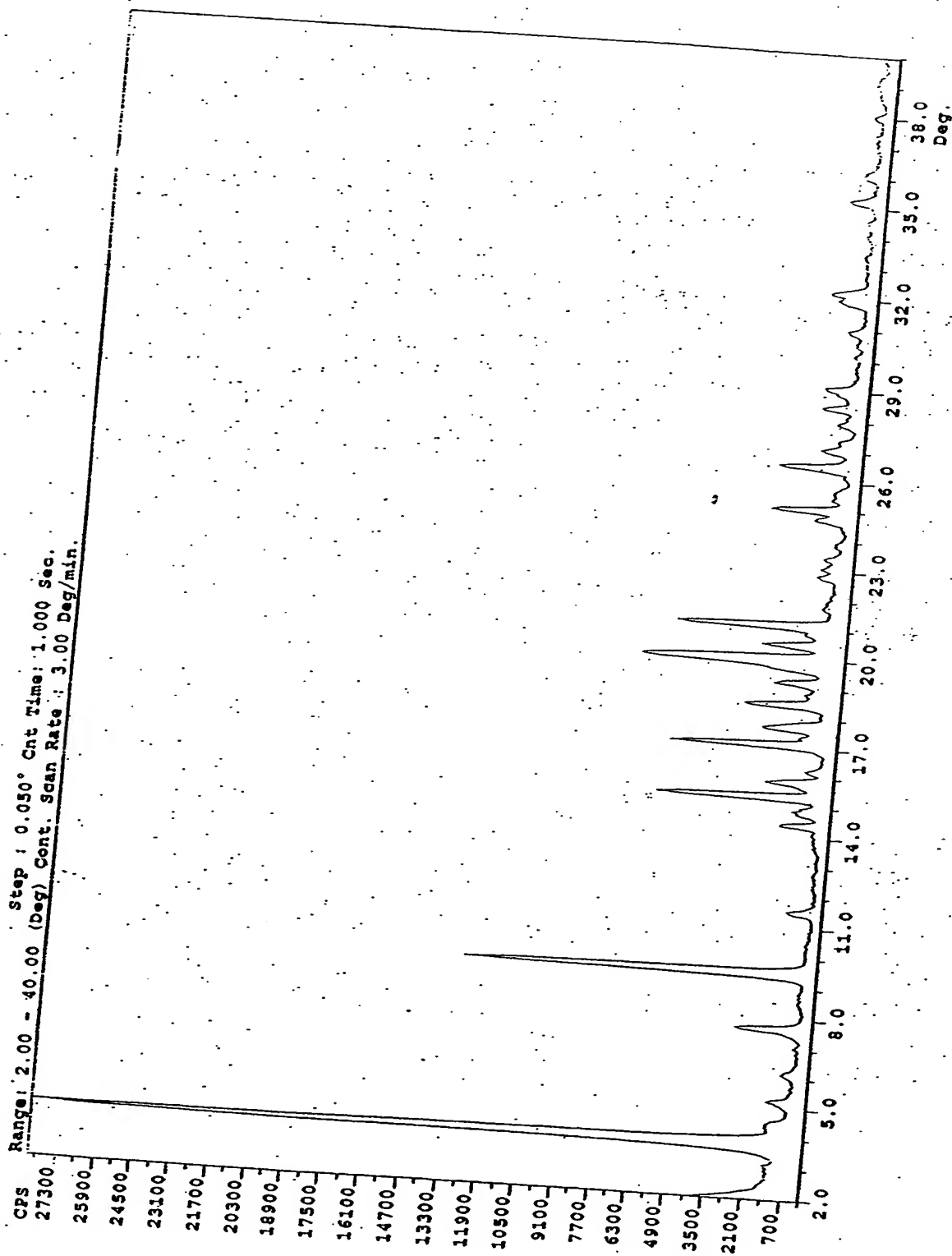


Fig. 10 L

Range: 2.00 - 40.00 (Deg) Cnt Time: 1.000 Sec.  
Step: 0.050 (Deg) Cont. Scan Rate: 3.00 Deg/min.

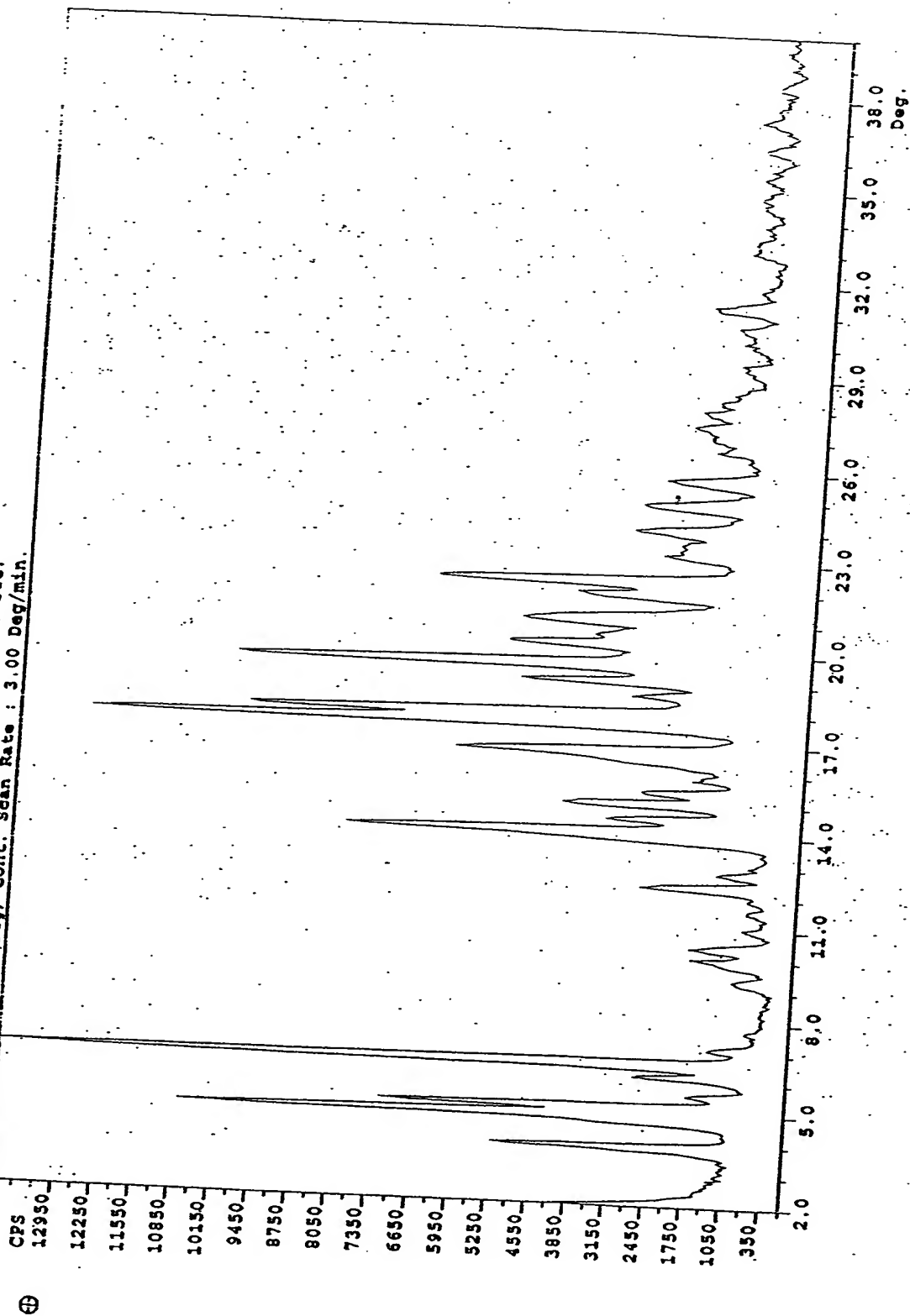


Fig. 11

M

Range: 2.00 - 40.00 (Deg) Cnt Time: 1.000 Sec.  
Step: 0.050 (Deg) Cont. Scan Rate: 3.00 Deg/min.

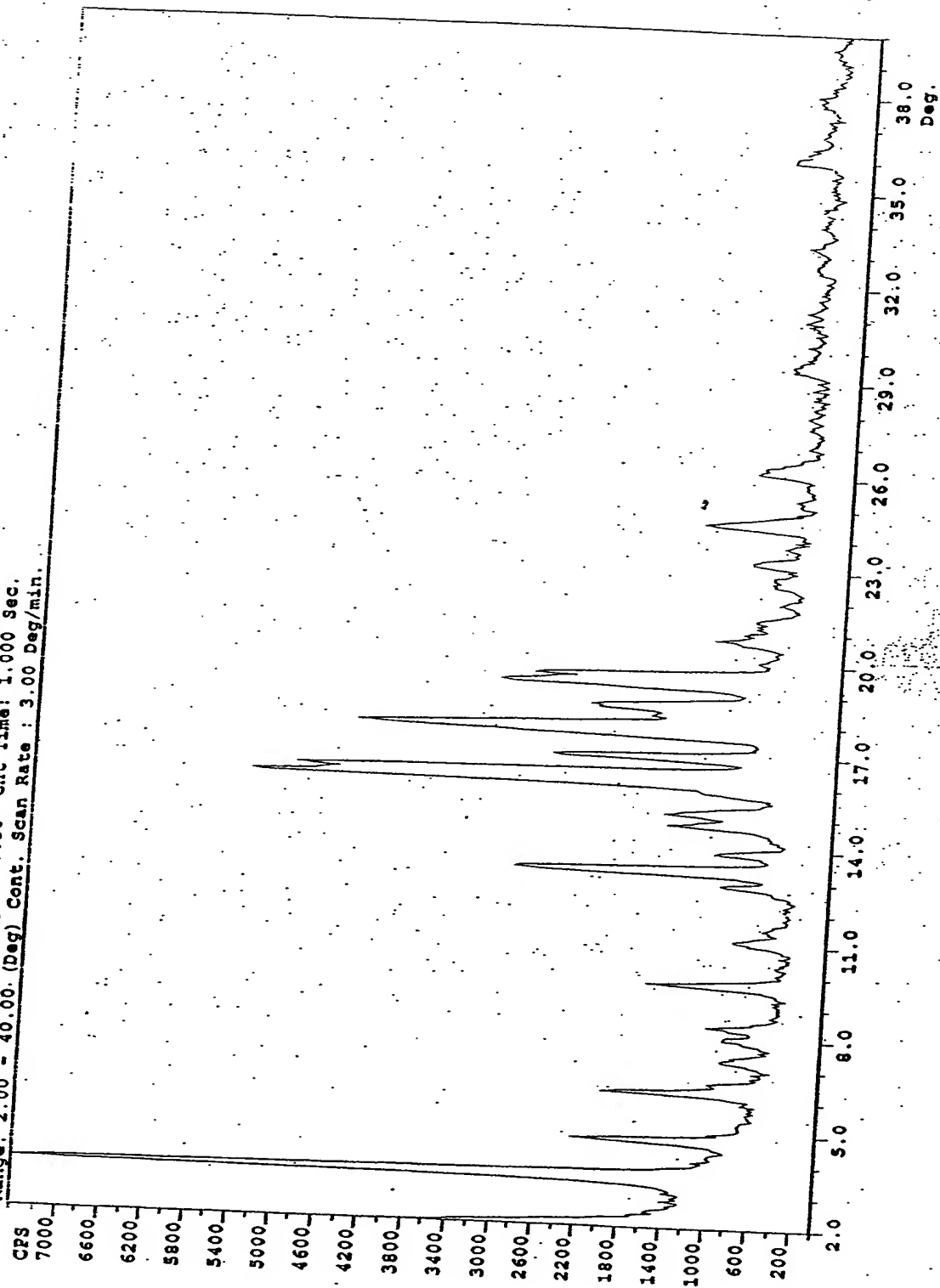


Fig. 12 N

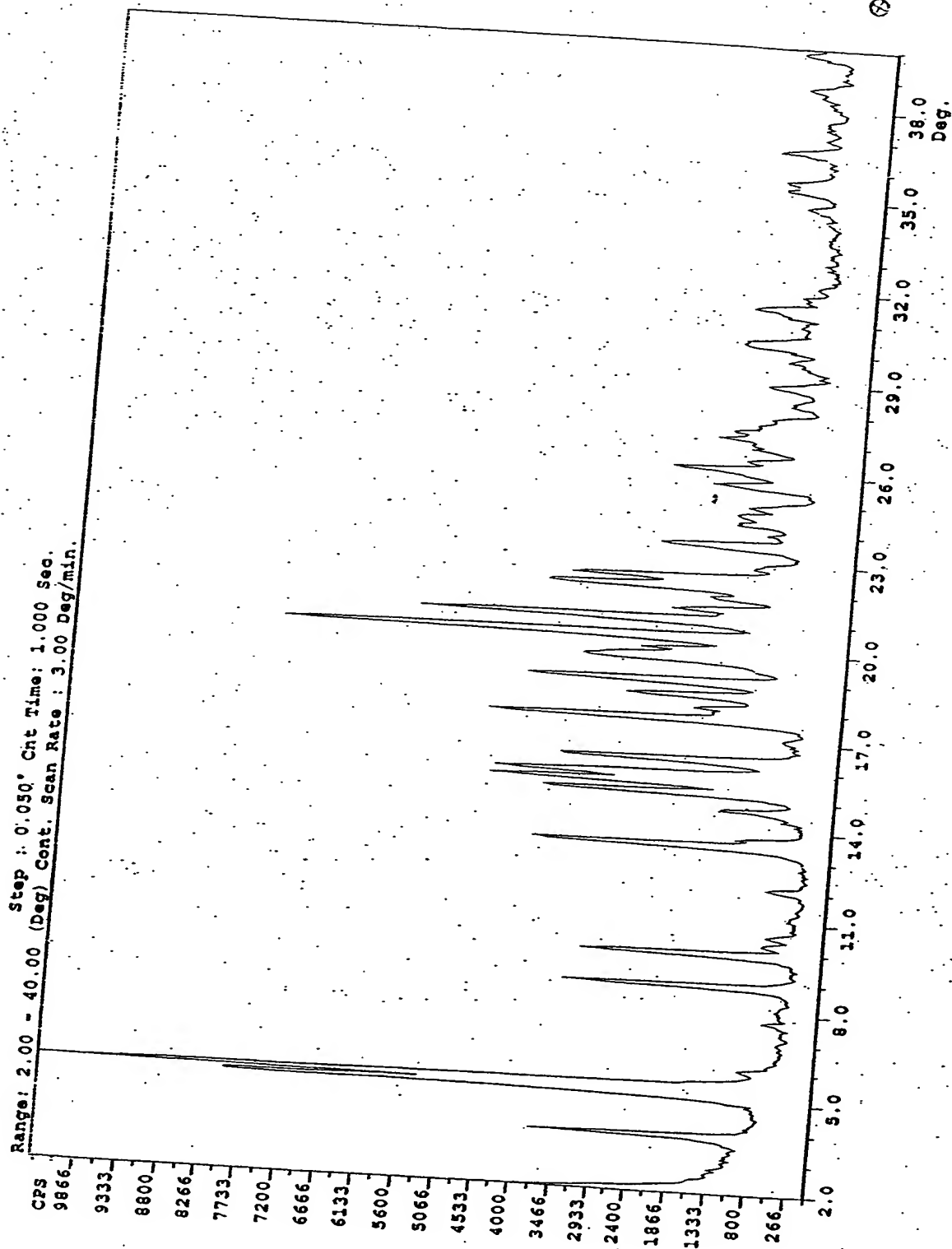


Fig. 13 0

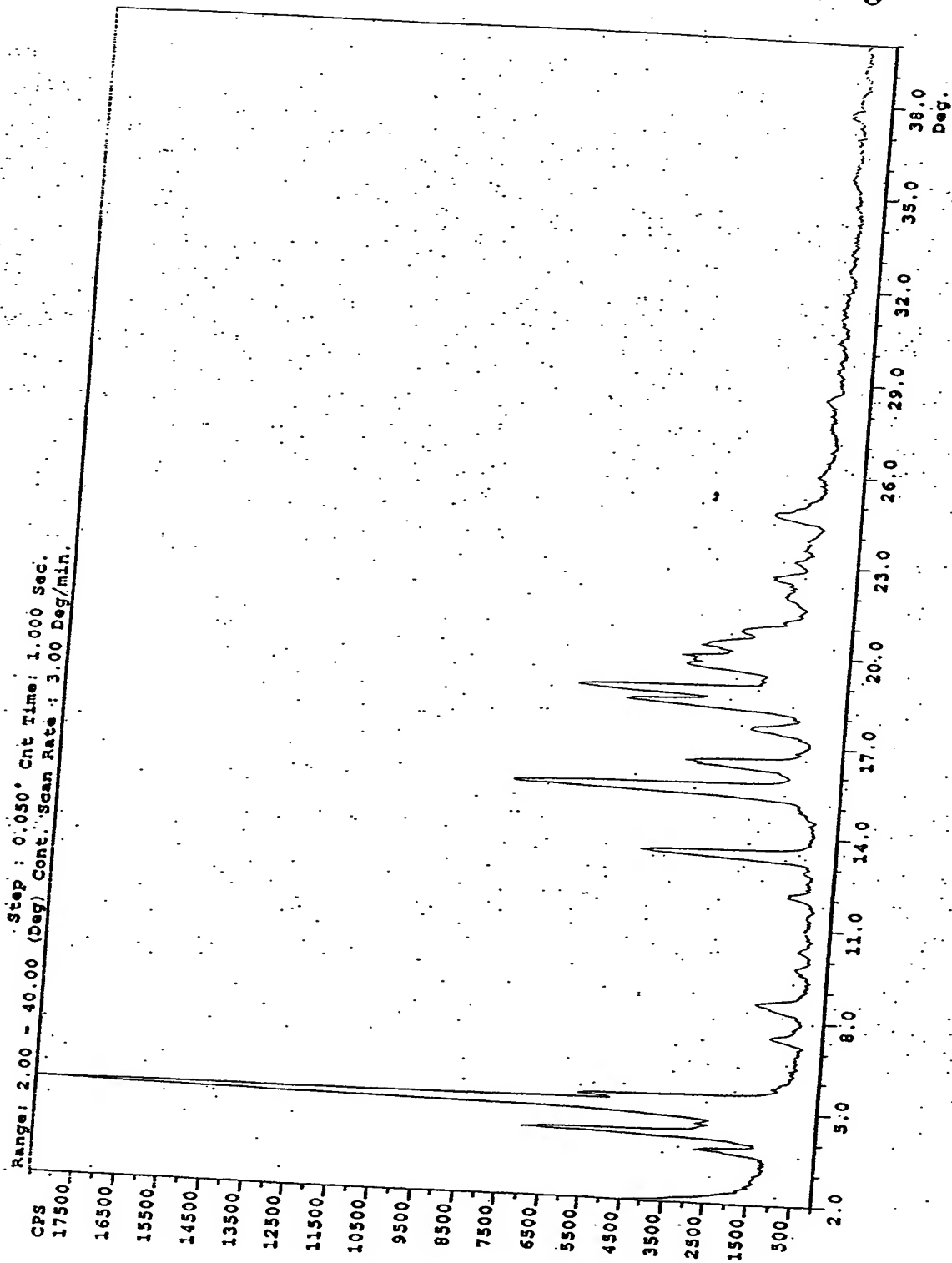


Fig. 14

P

Range: 2.00 - 40.00 Step: 0.050° Cnt Time: 1.000 Sec.  
18900 (Deg) Cont. Scan Rate: 3.00 Deg/min.

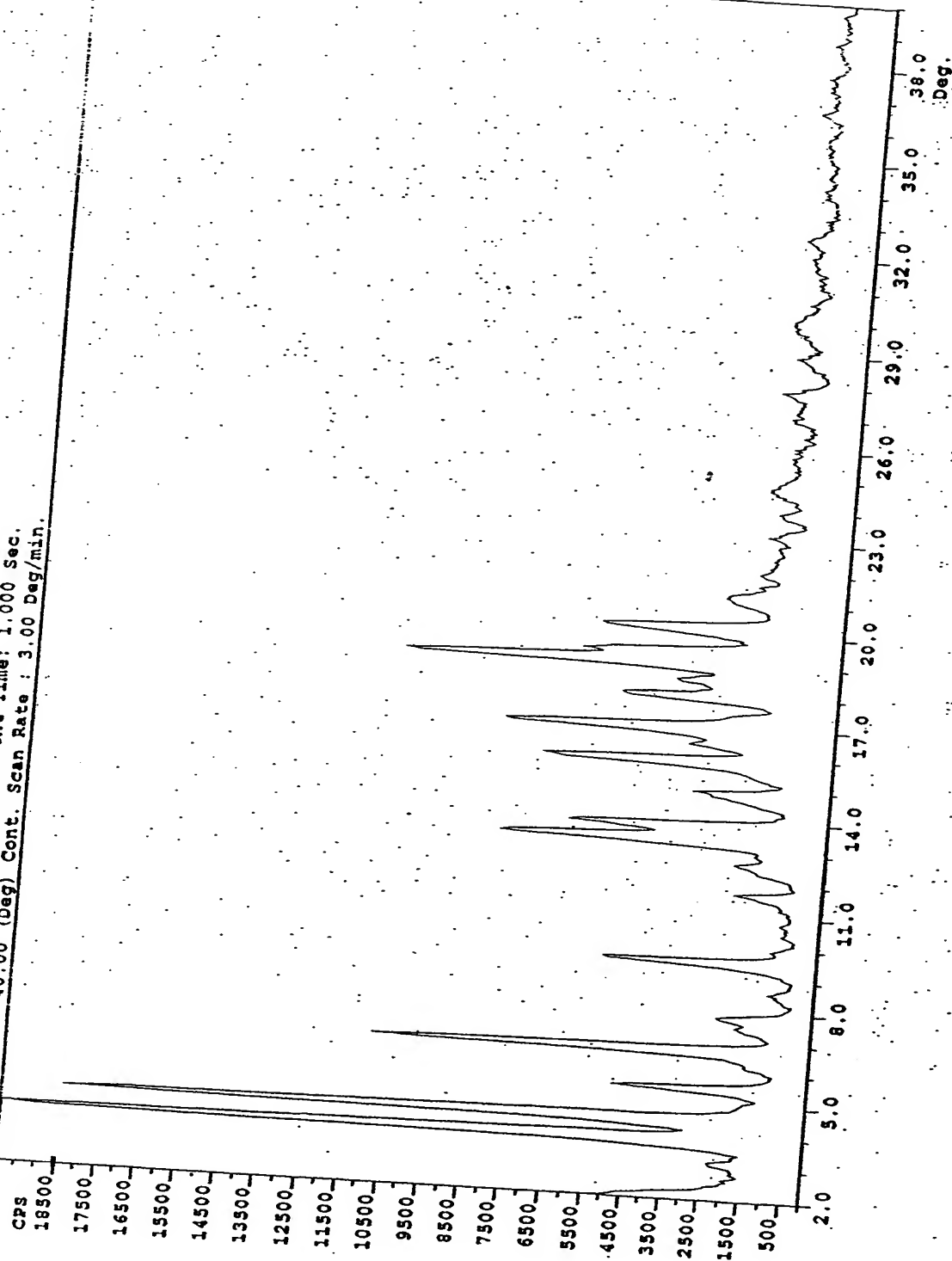


Fig. 15 Q

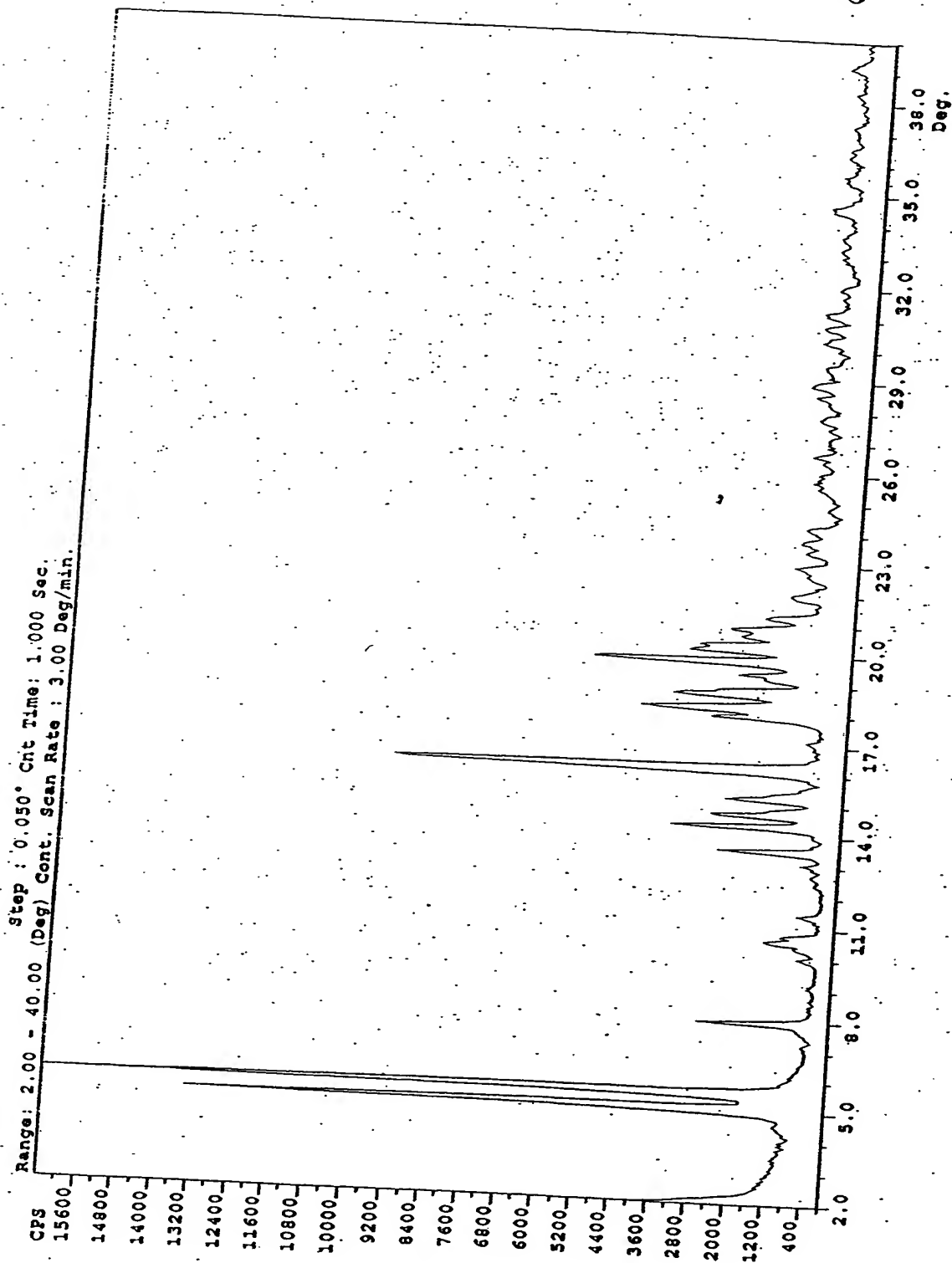


Fig. 16

T

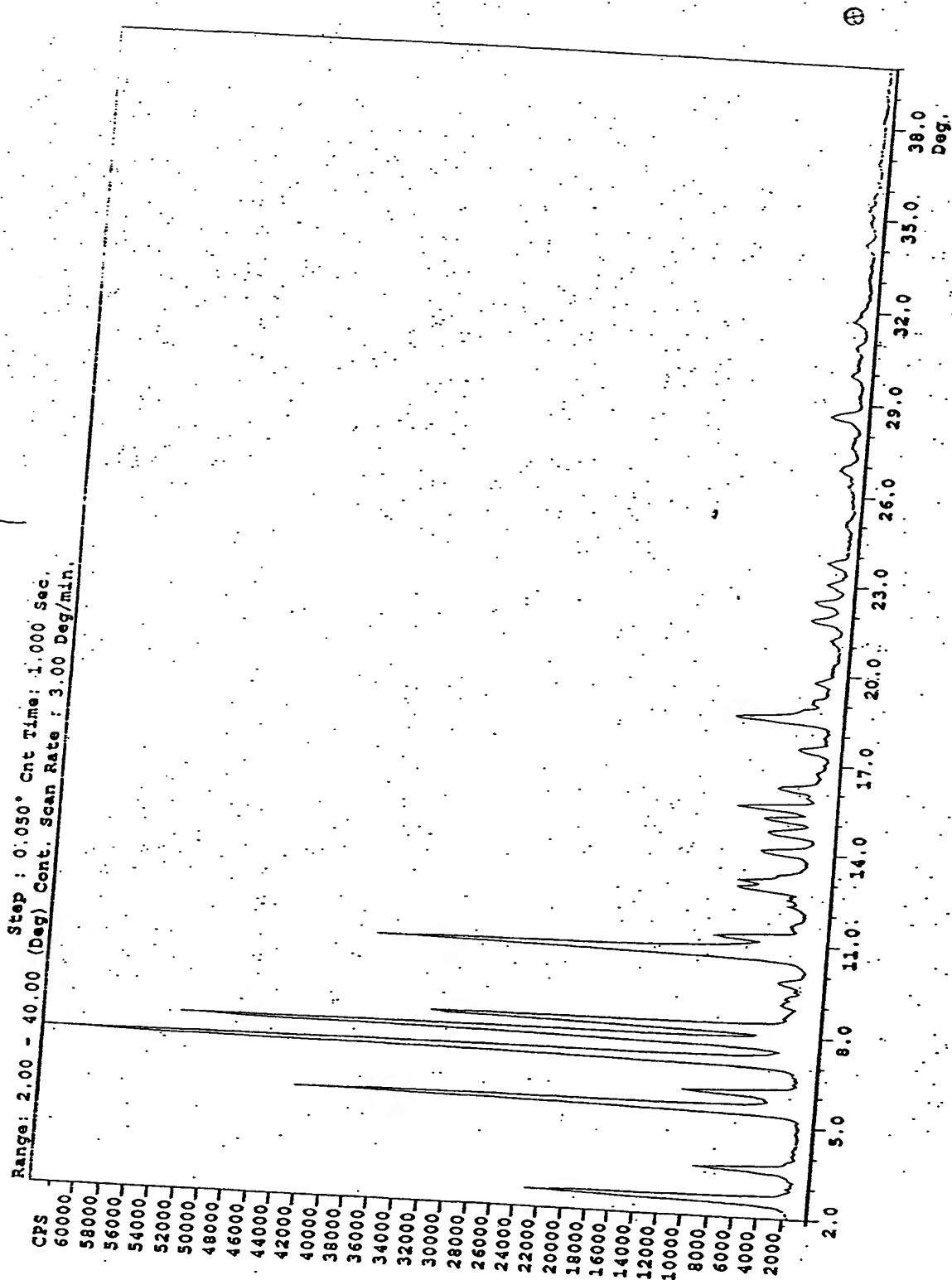




Fig. 17 u

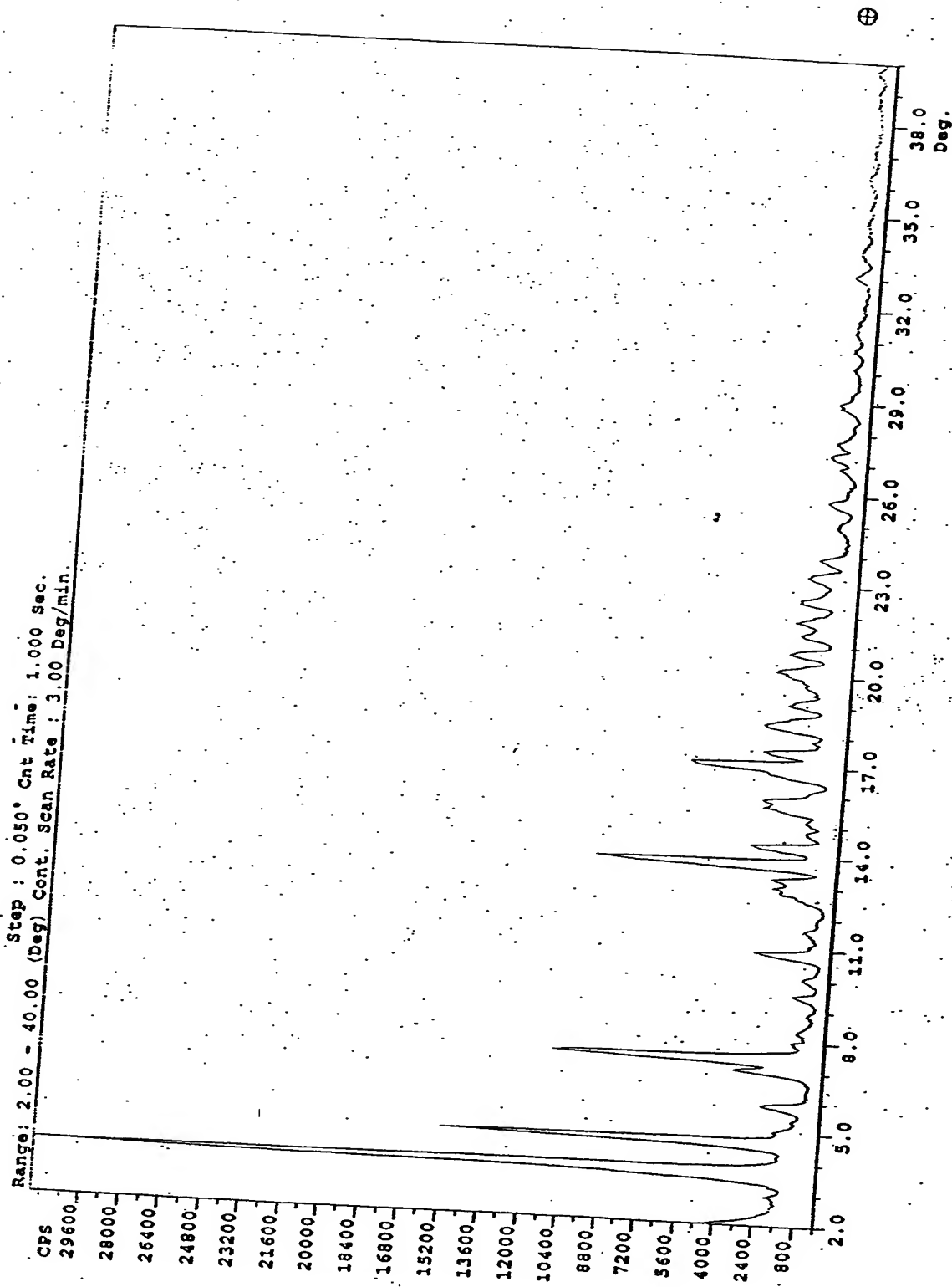


Fig. 18

V

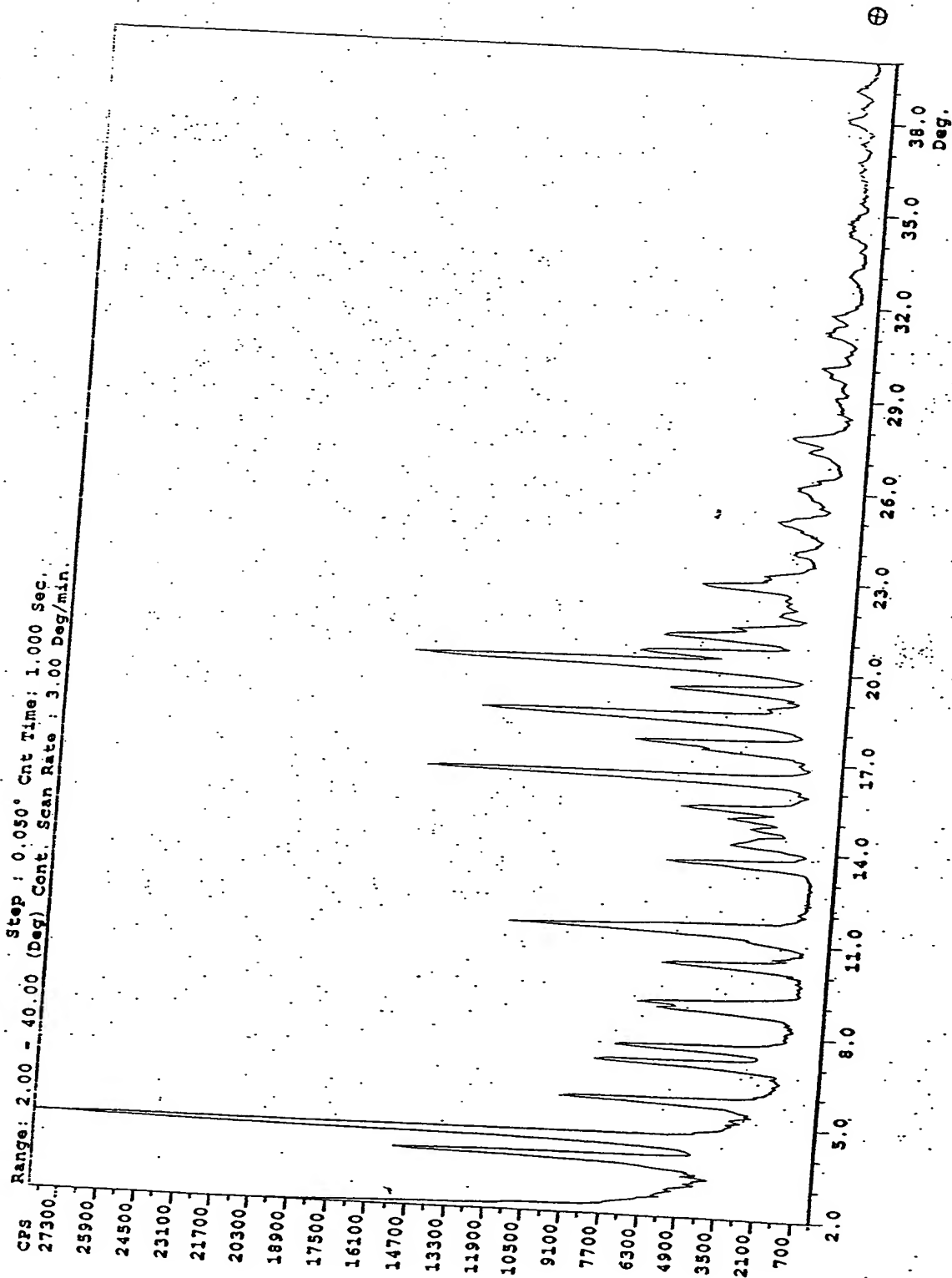


Fig 19

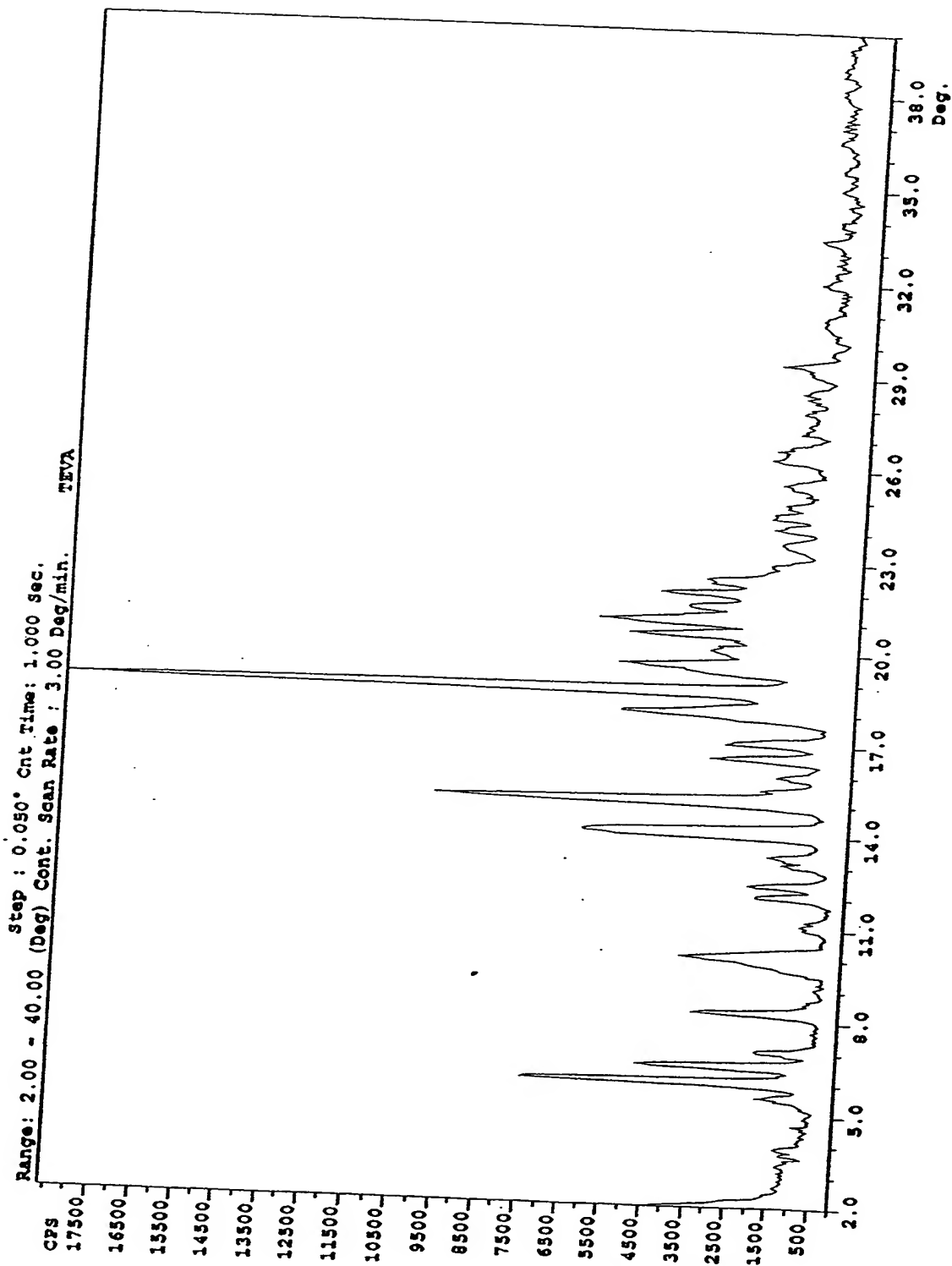


Figure 20 - Nateglinide Form Z

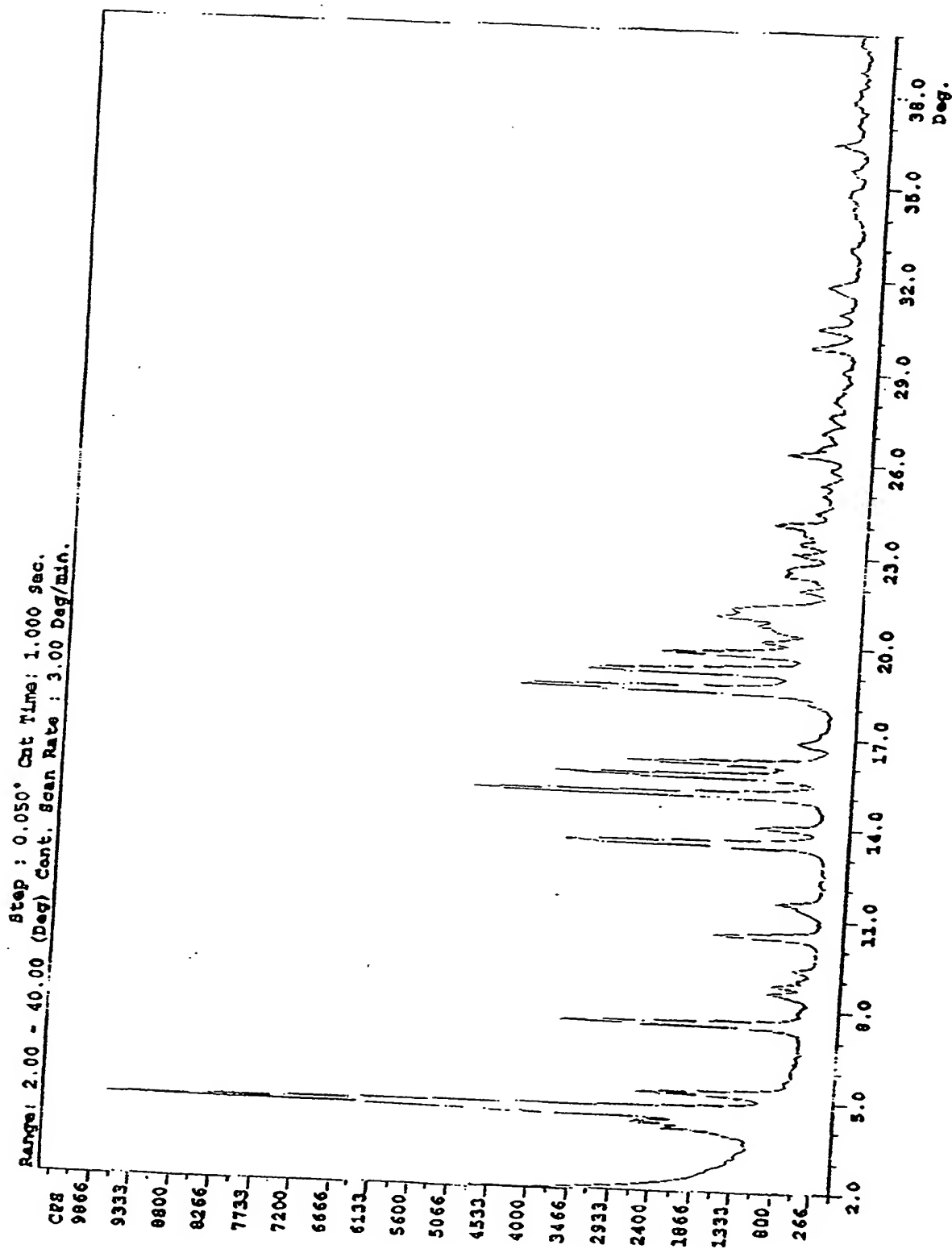


fig 2p x

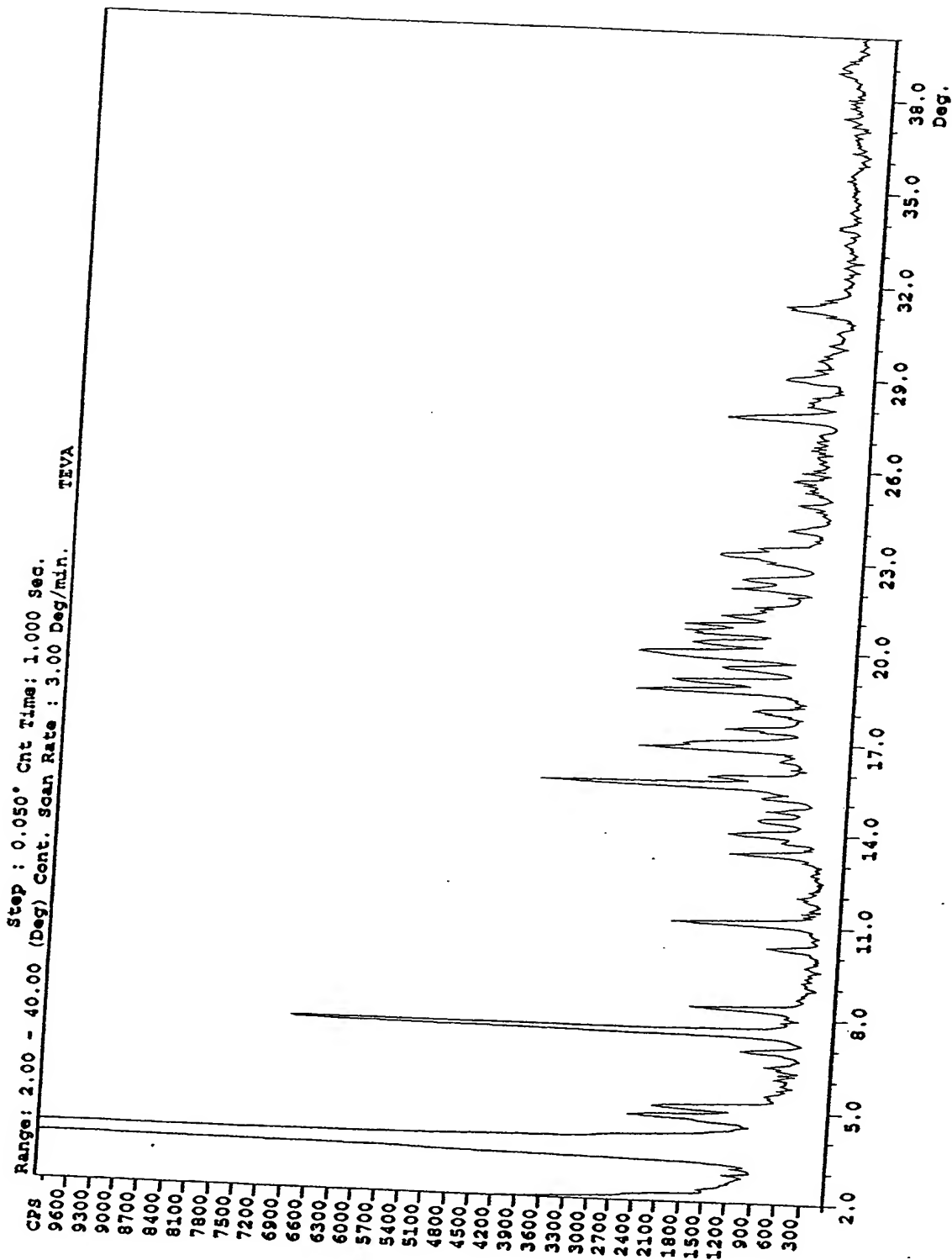


Fig. 2a B

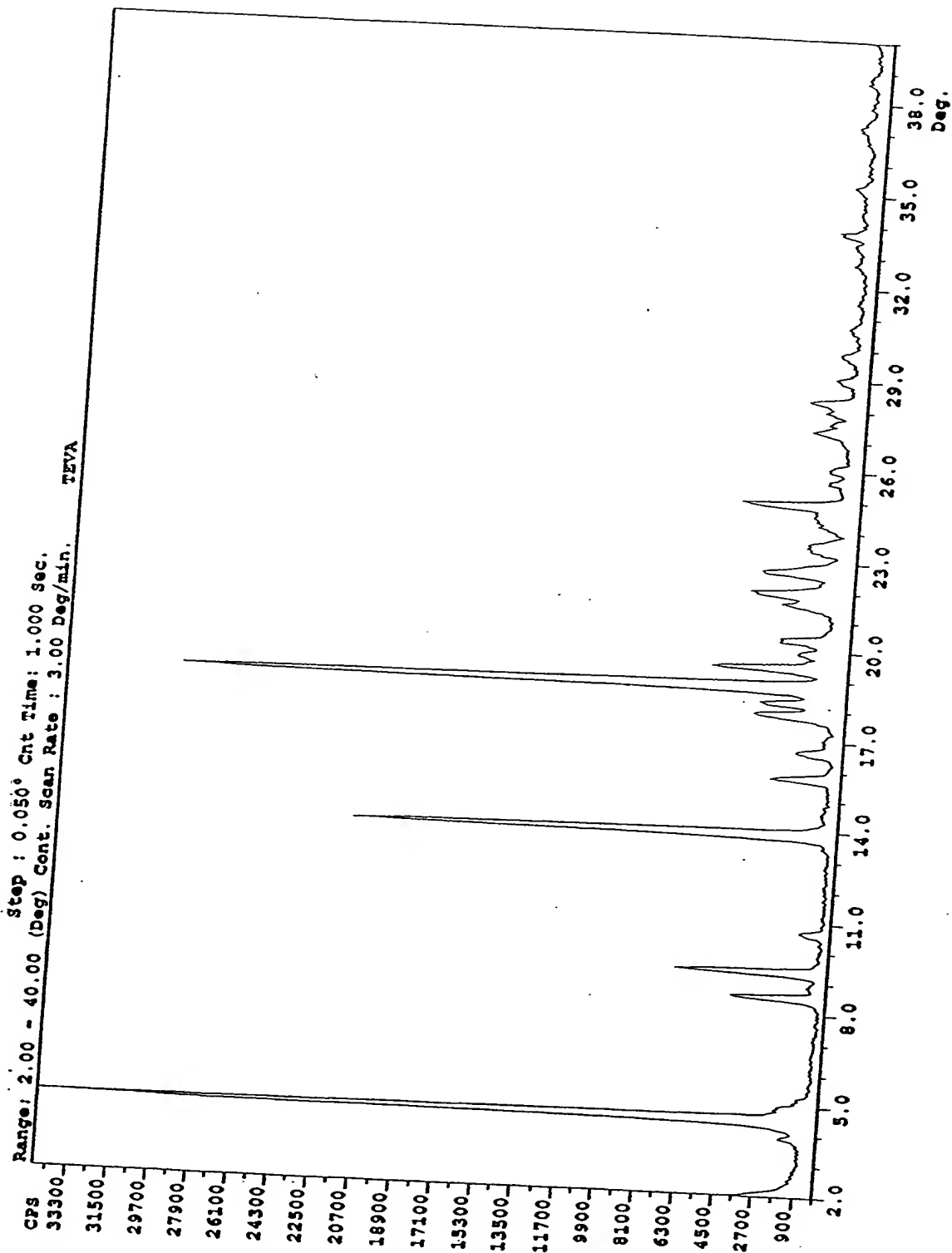


Fig 23 10

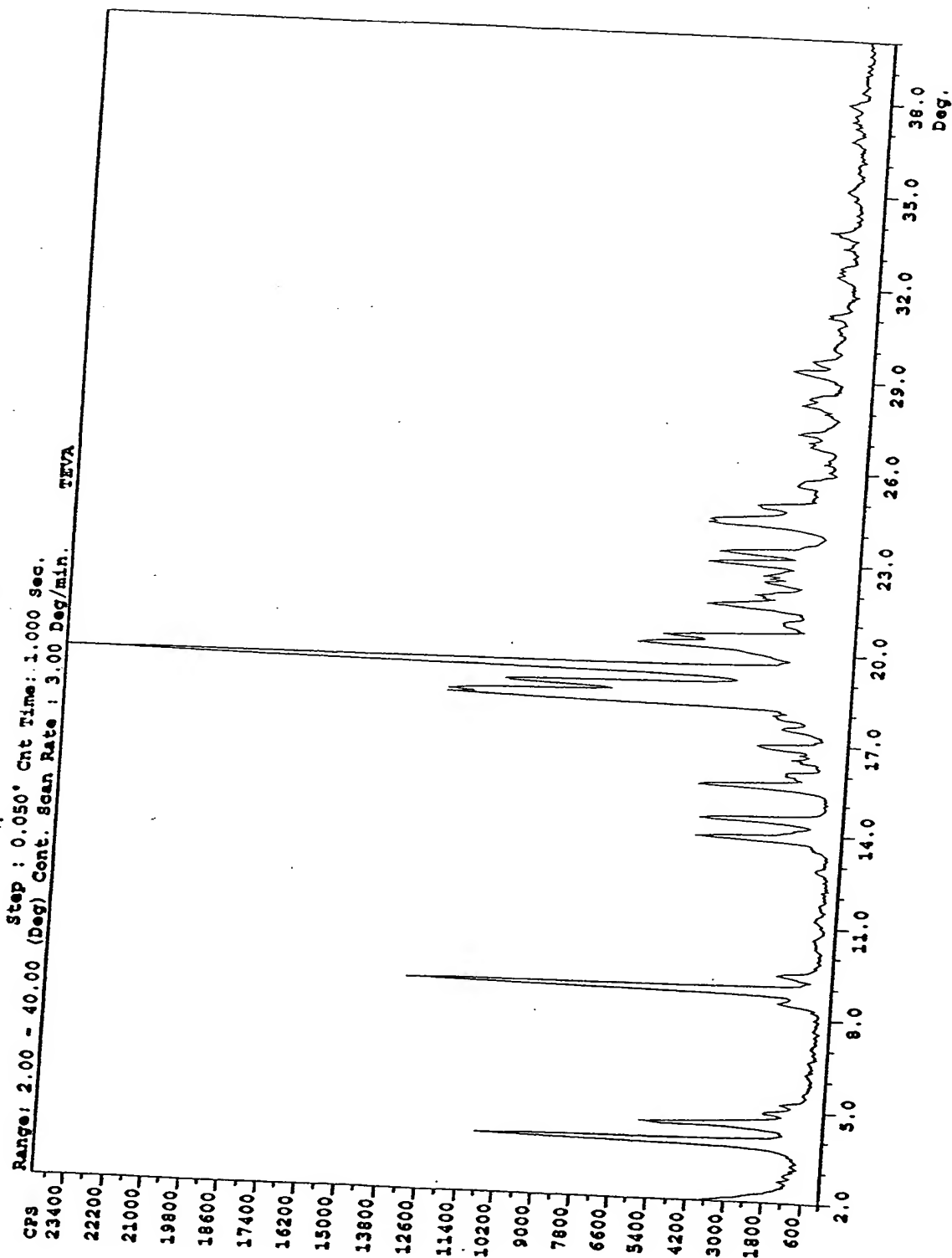


Fig 24

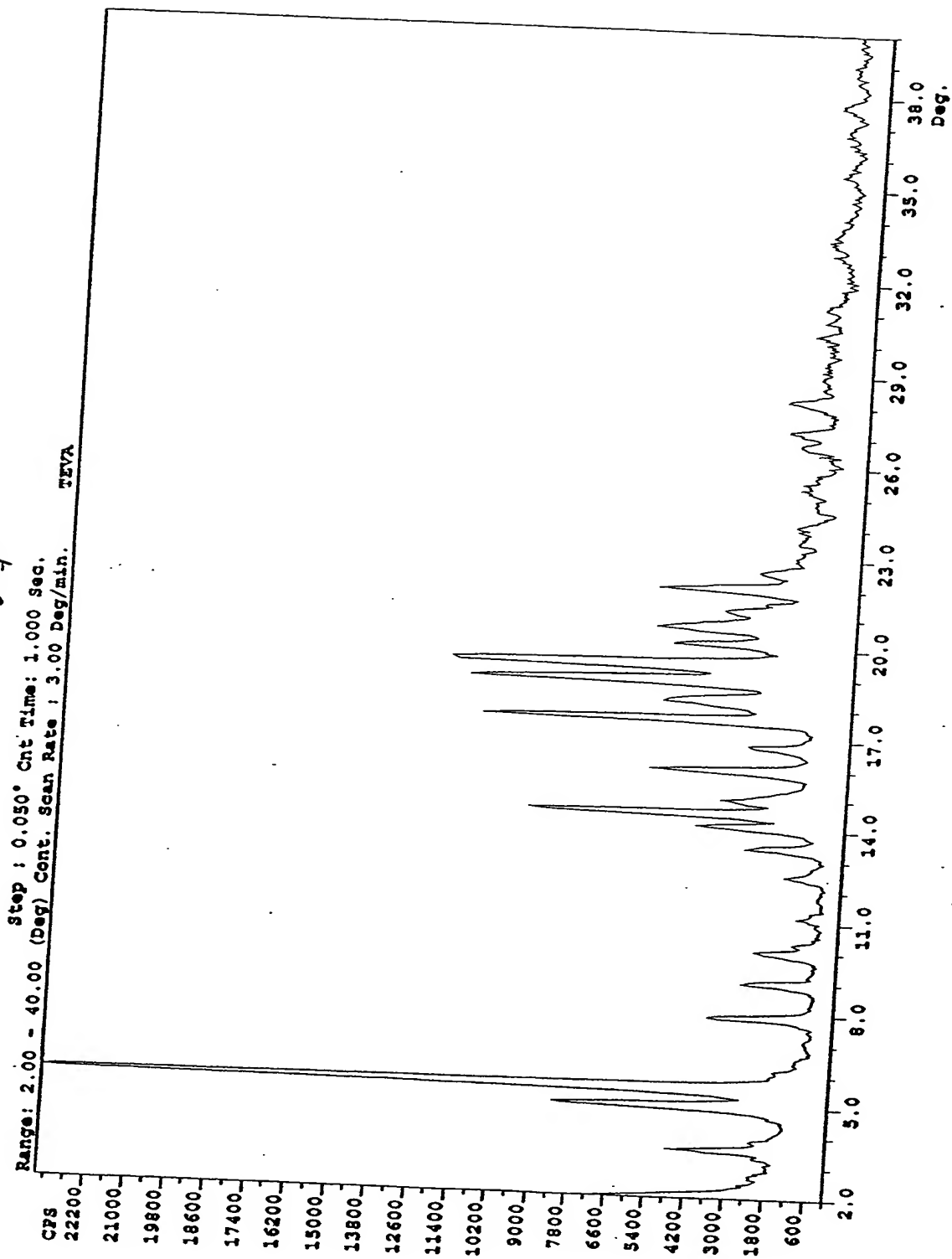




fig 25

E

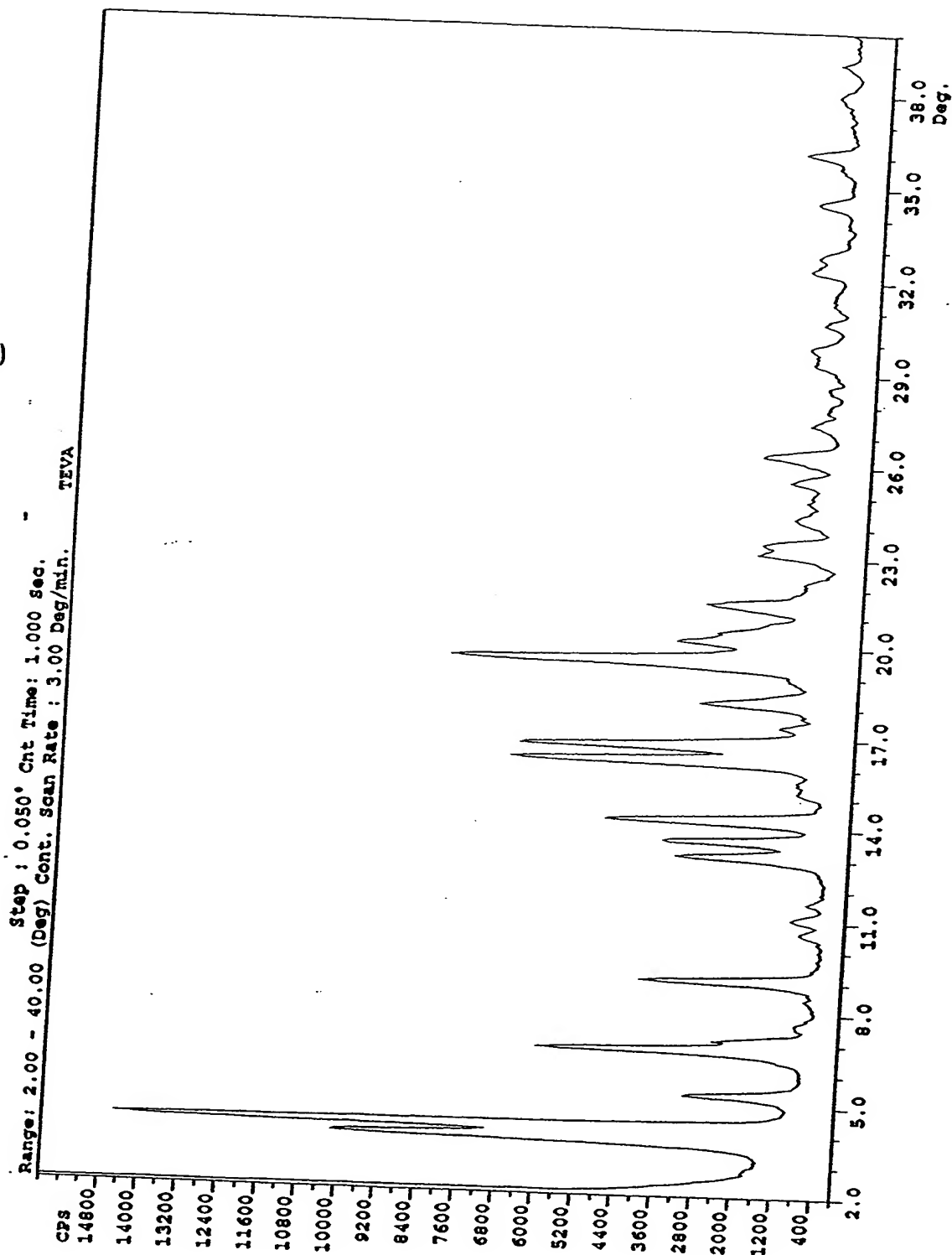
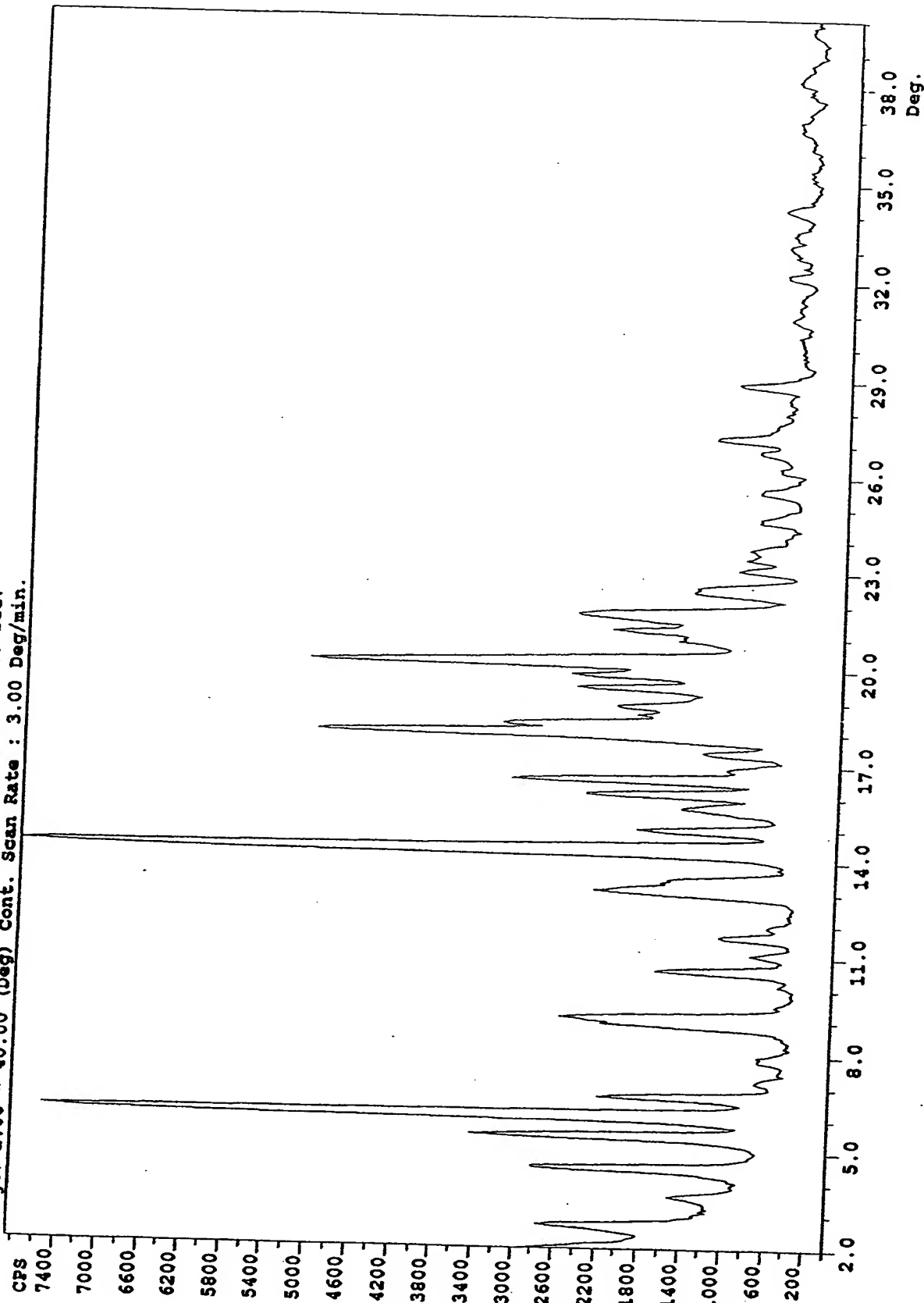


FIGURE 26

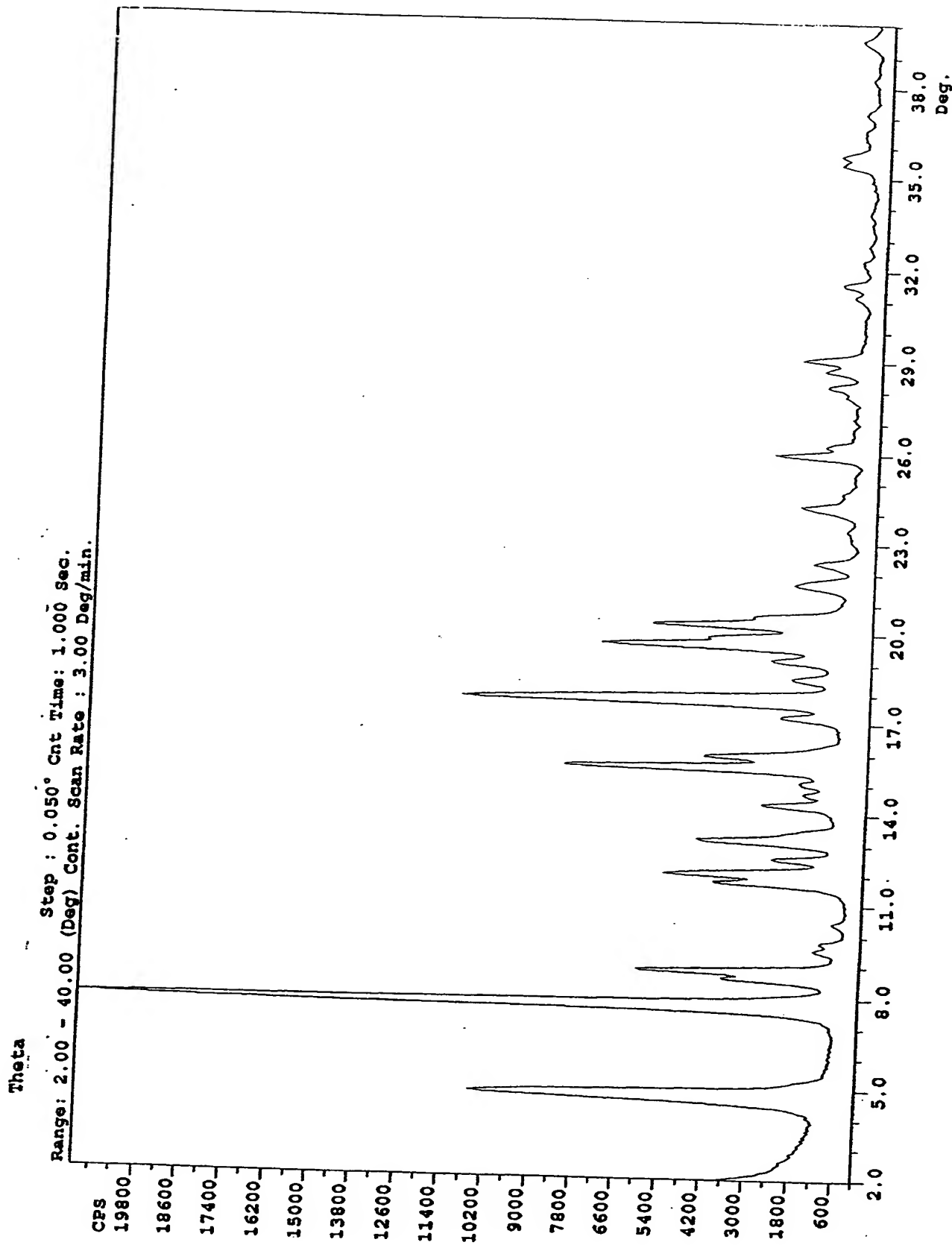
Sigma

Range: 2.00 - 40.00 (Deg) Step: 0.050° Cnt Time: 1.000 Sec.  
Cont. Scan Rate: 3.00 Deg/min.



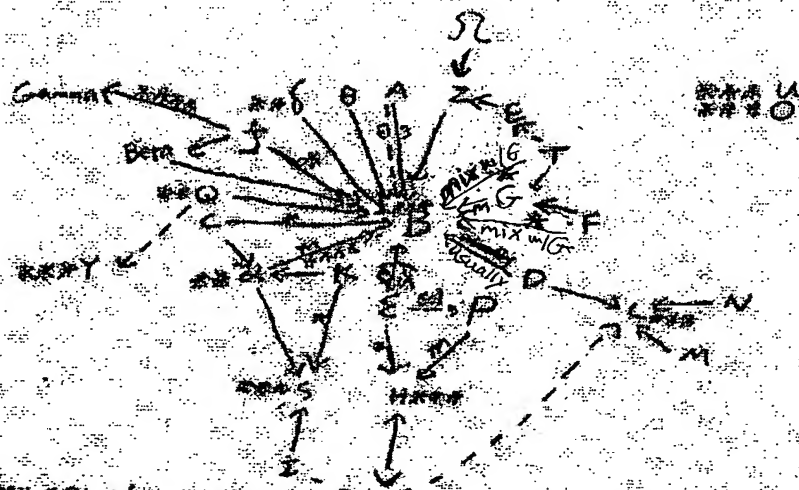
Form 2 (5)

FIGURE 28



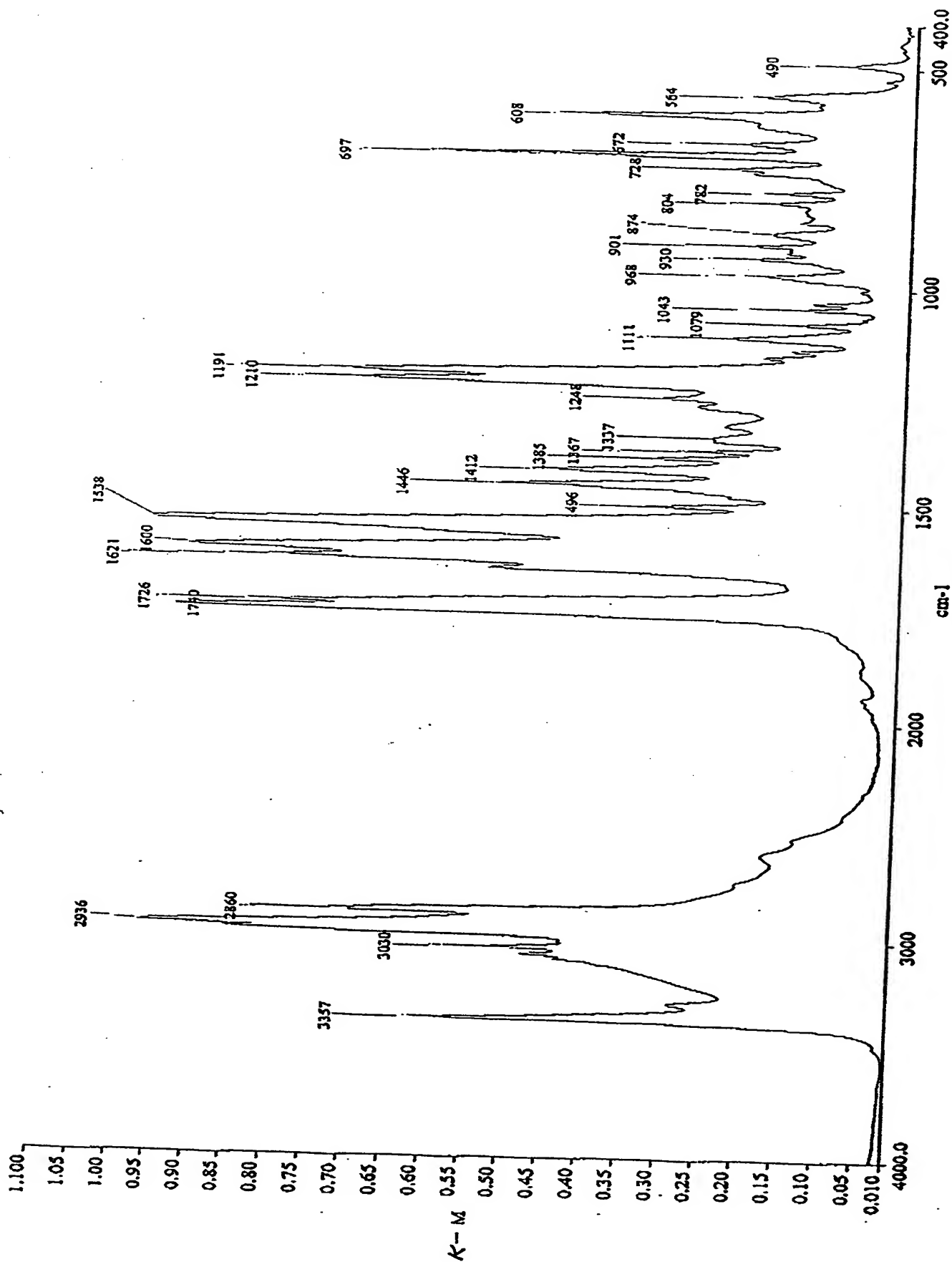
Form 8

Figure 28 - Thermal stability chart



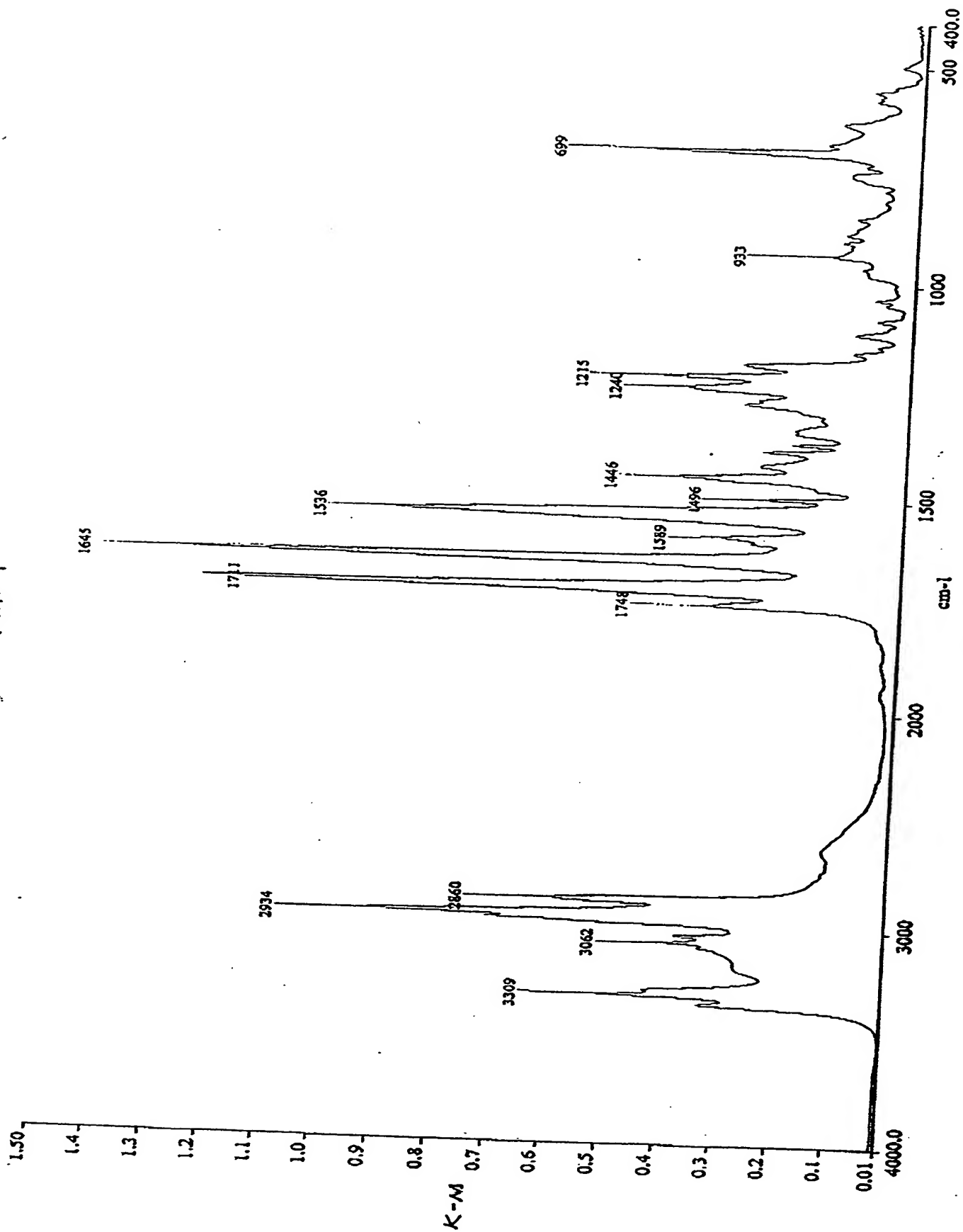
\* Transformation may proceed through another form  
 \*\* Thermally stable at lower heating temperatures ( $\sim 50^{\circ}\text{C}$ )  
 \*\*\* Thermally stable forms  
 --- Transformation after storage at room temperature  
 - - - Mixture with starting form.  
 \*\*\*\* When starting material contains seeds.  
 Sol Results might vary depending on the solvate of form epitaxial used.

FIGURE 29  
Form



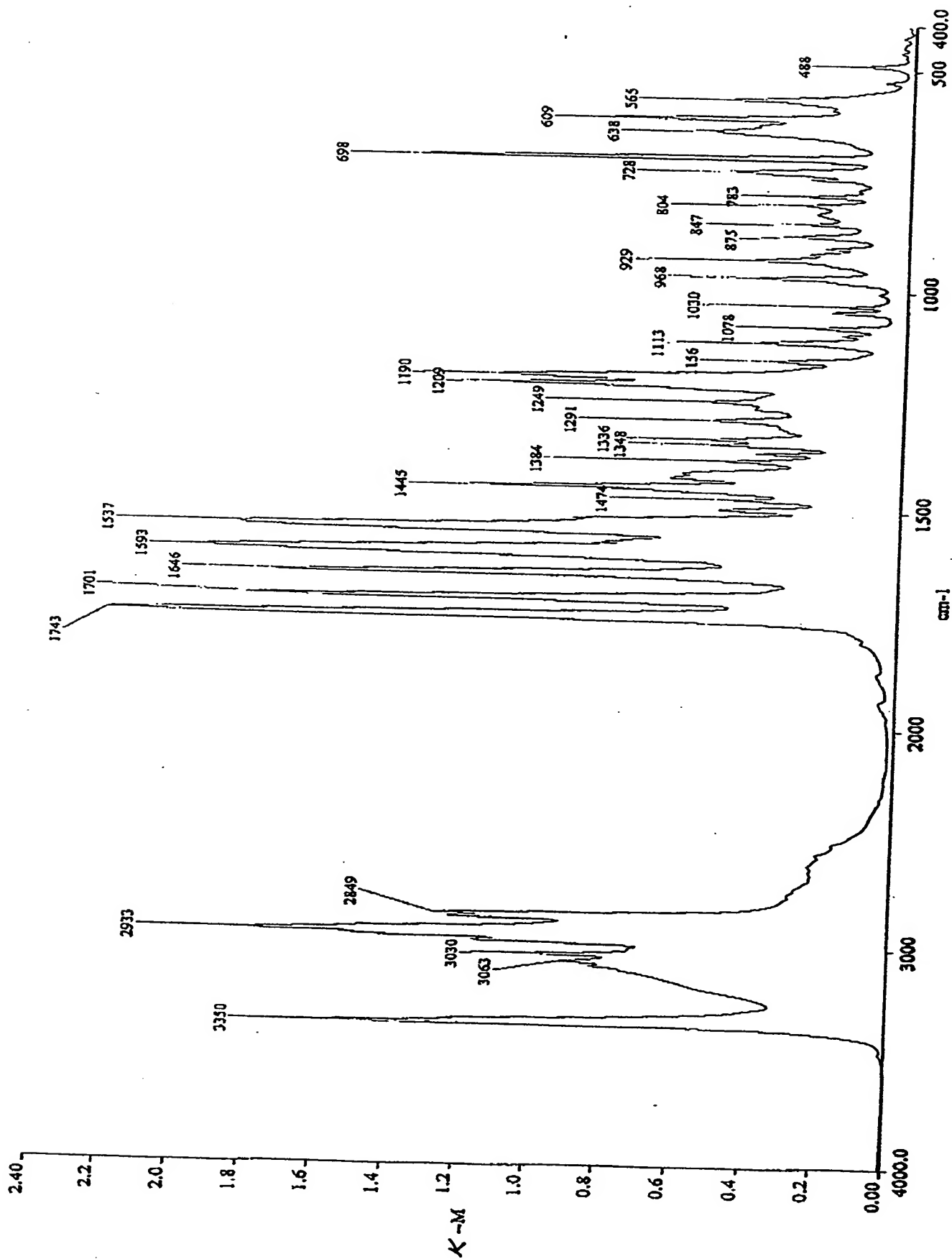
-DRIFT, 4000-400 CM-1, 16 scans, Resolution: 4.00cm-1

FIGURE 30  
- Corn P



DRIFT, 4000-400 CM<sup>-1</sup>, 16 scans, Resolution: 4.00cm<sup>-1</sup>

FIGURE 30  
Form U



DRIFT, 4000-400cm-1, 19 scans, resolution: 4.0cm-1

32  
Figure 32 - Nateglinide Form Z

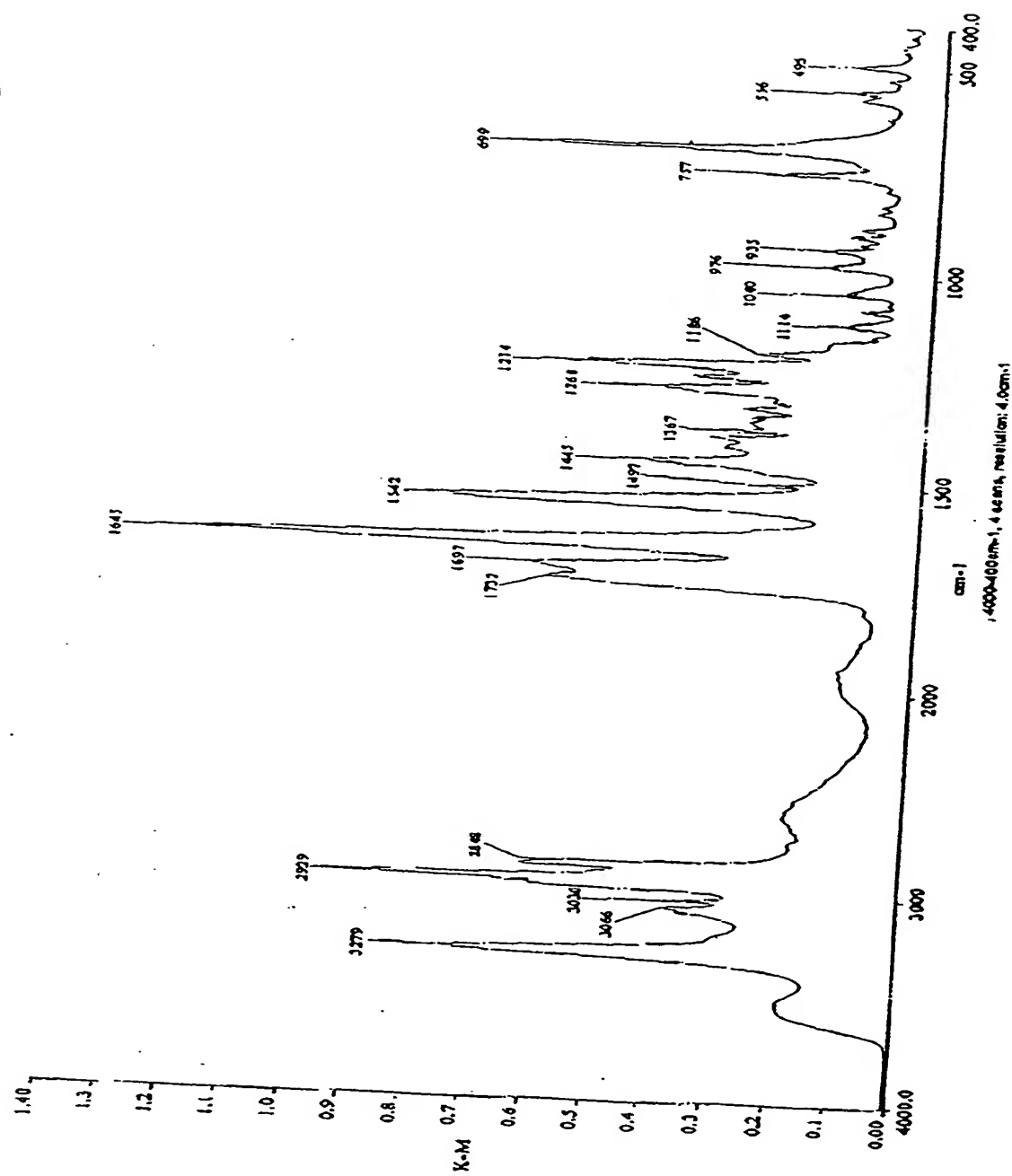
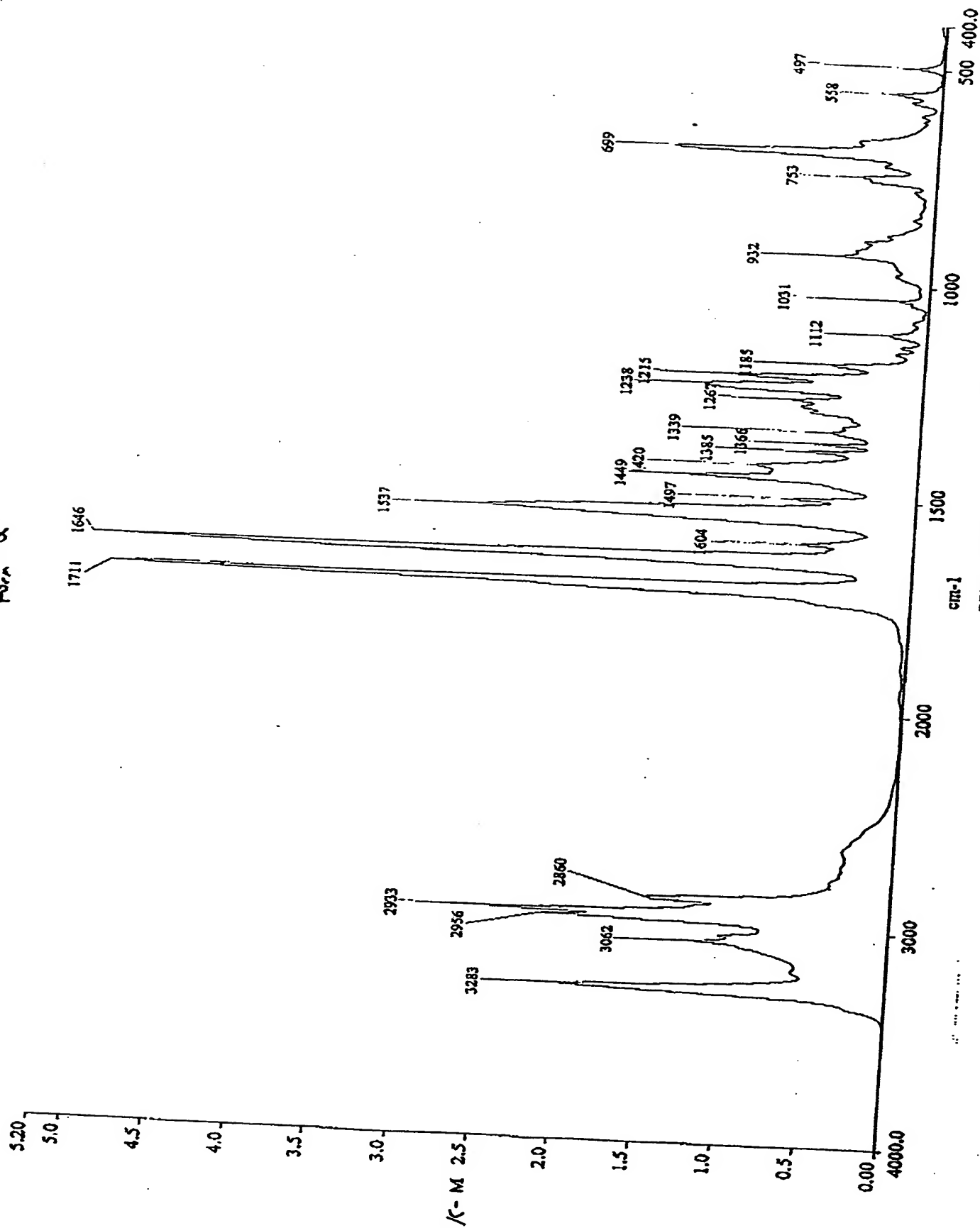


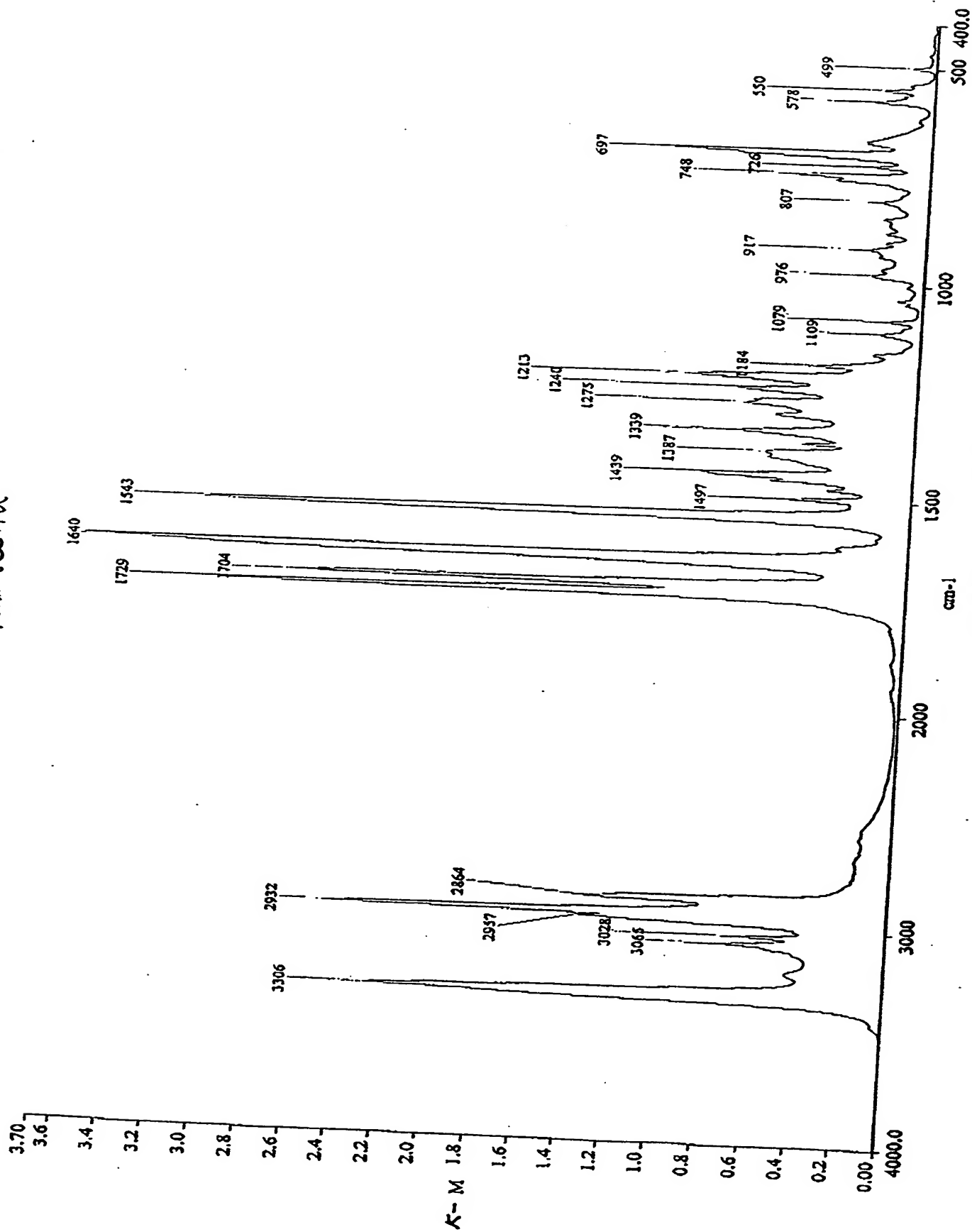


FIGURE 3  
Form  $\alpha$



DRIFT, 4000-400  $\text{cm}^{-1}$ , 16 scans, Resolution: 4.00  $\text{cm}^{-1}$

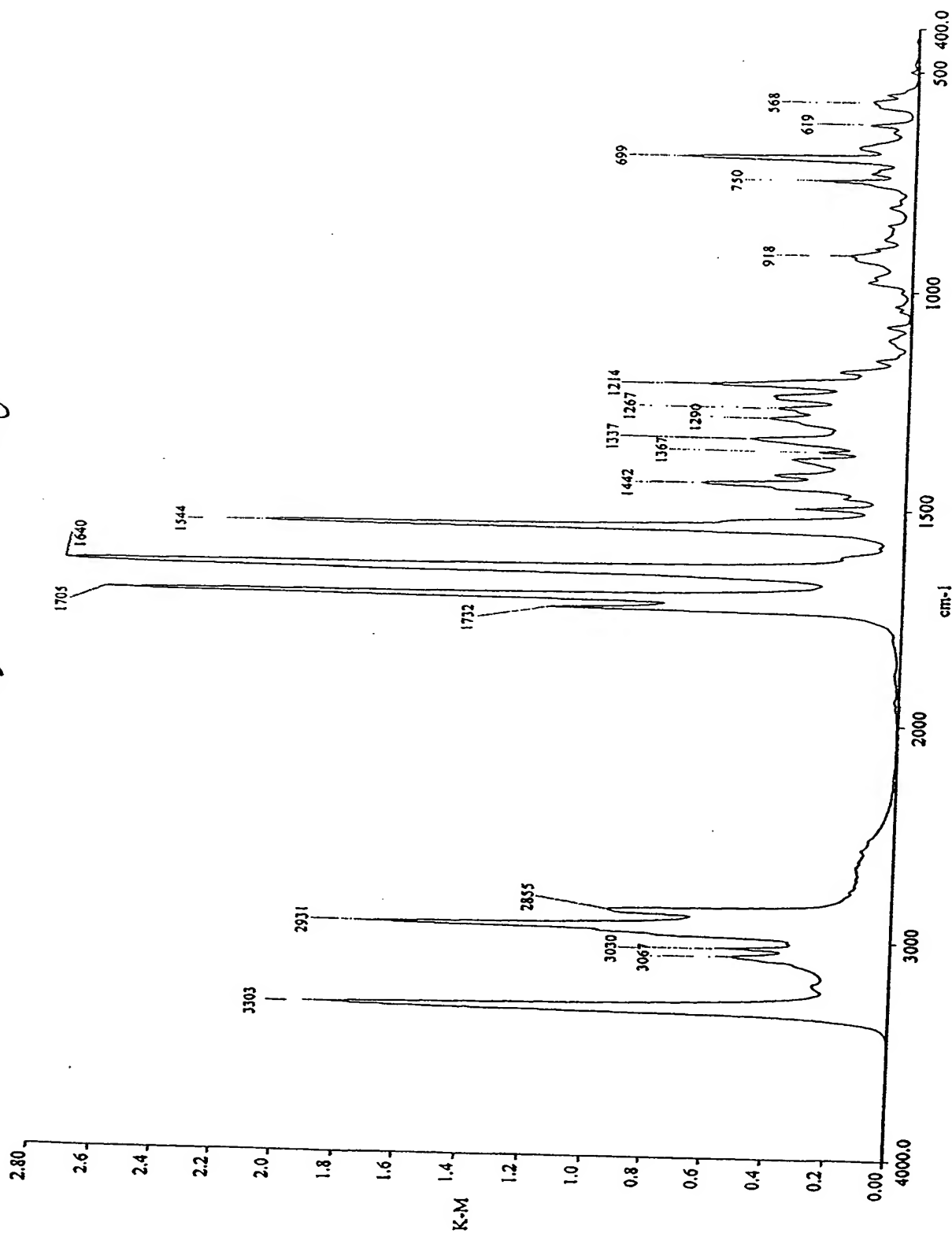
FIGURE 34 Form delta



DRIFT, 4000-400cm<sup>-1</sup>, 16 scans, resolution: 4.0cm<sup>-1</sup>

FIGURE 35

- form



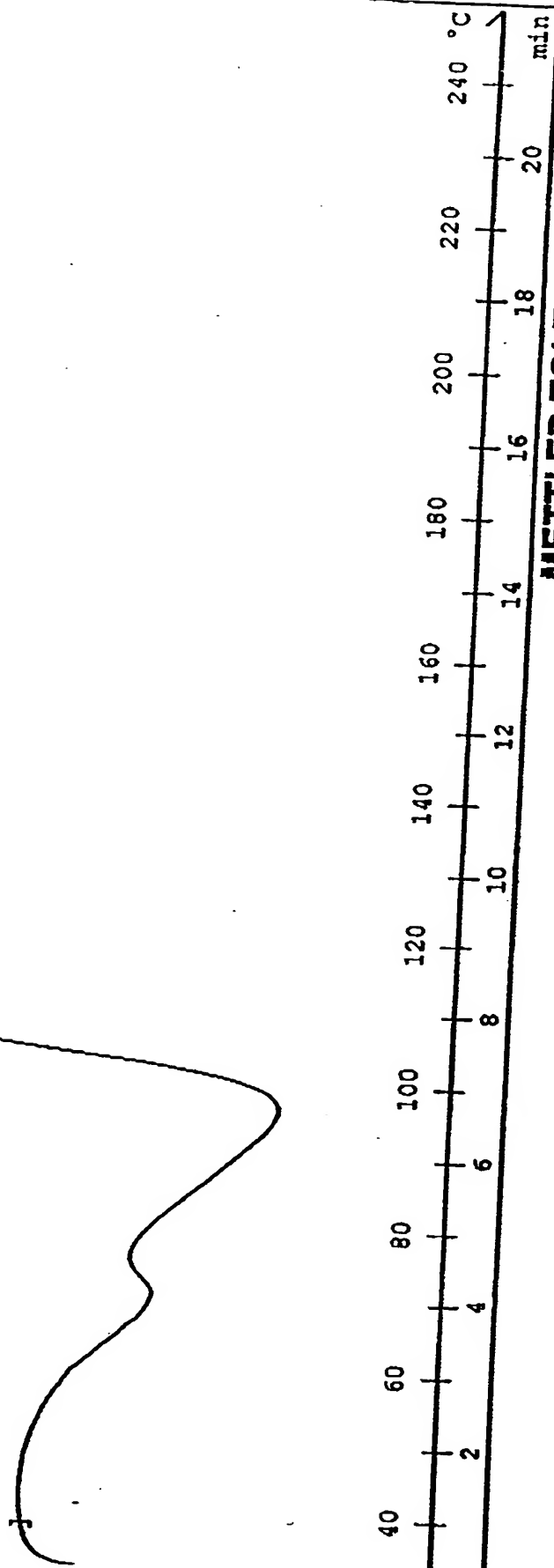
DRIFT, 4000-400CM-1, 16 SCANS RESOLUTION: 4.0CM-1

form (O)

FIGURE 36

Form A

Method: 30-250C, 10C/min, 40ml/min N<sub>2</sub>  
30.0-250.0°C 10.00°C/min N<sub>2</sub>, 40.0 ml/min

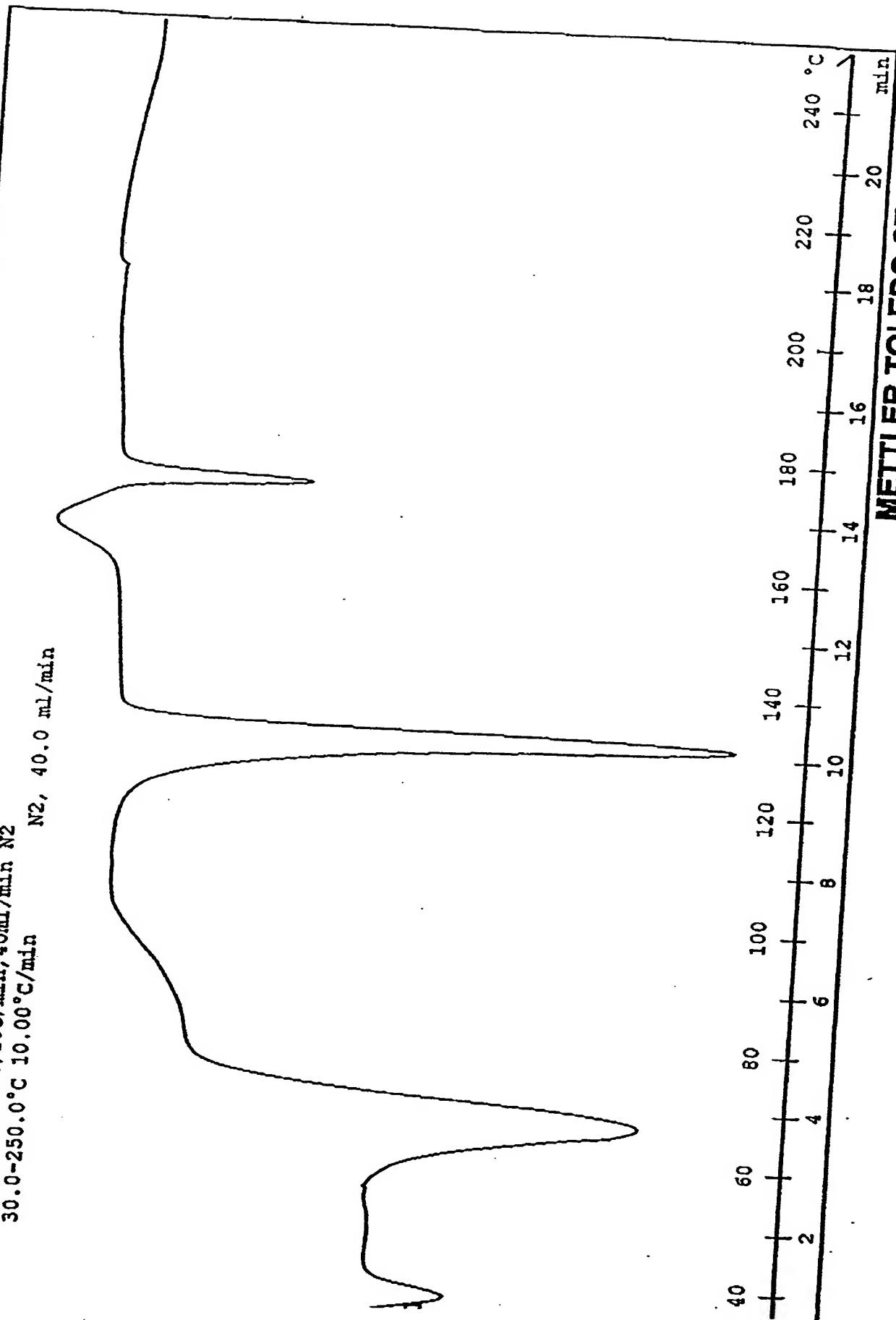


METTLER TOLEDO STAR® System

FIGURE 37

Form D

Method: 30-250°C, 10°C/min, 40ml/min N<sub>2</sub>  
30.0-250.0°C 10.00°C/min  
N<sub>2</sub>, 40.0 ml/min



METTLER TOLEDO STAR® System

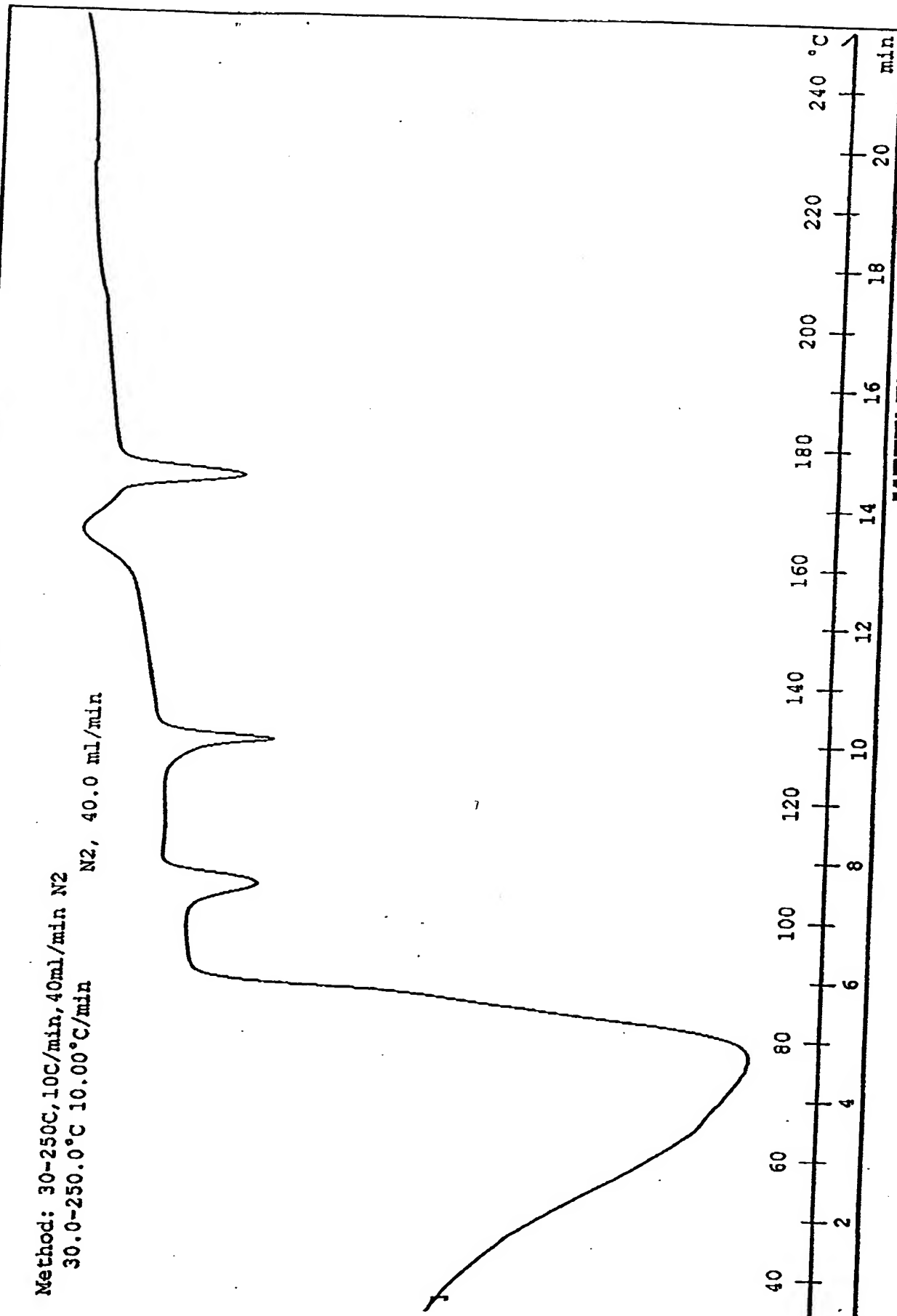
FIGURE 38

Form E

Method: 30-250°C, 10°C/min, 40ml/min N<sub>2</sub>

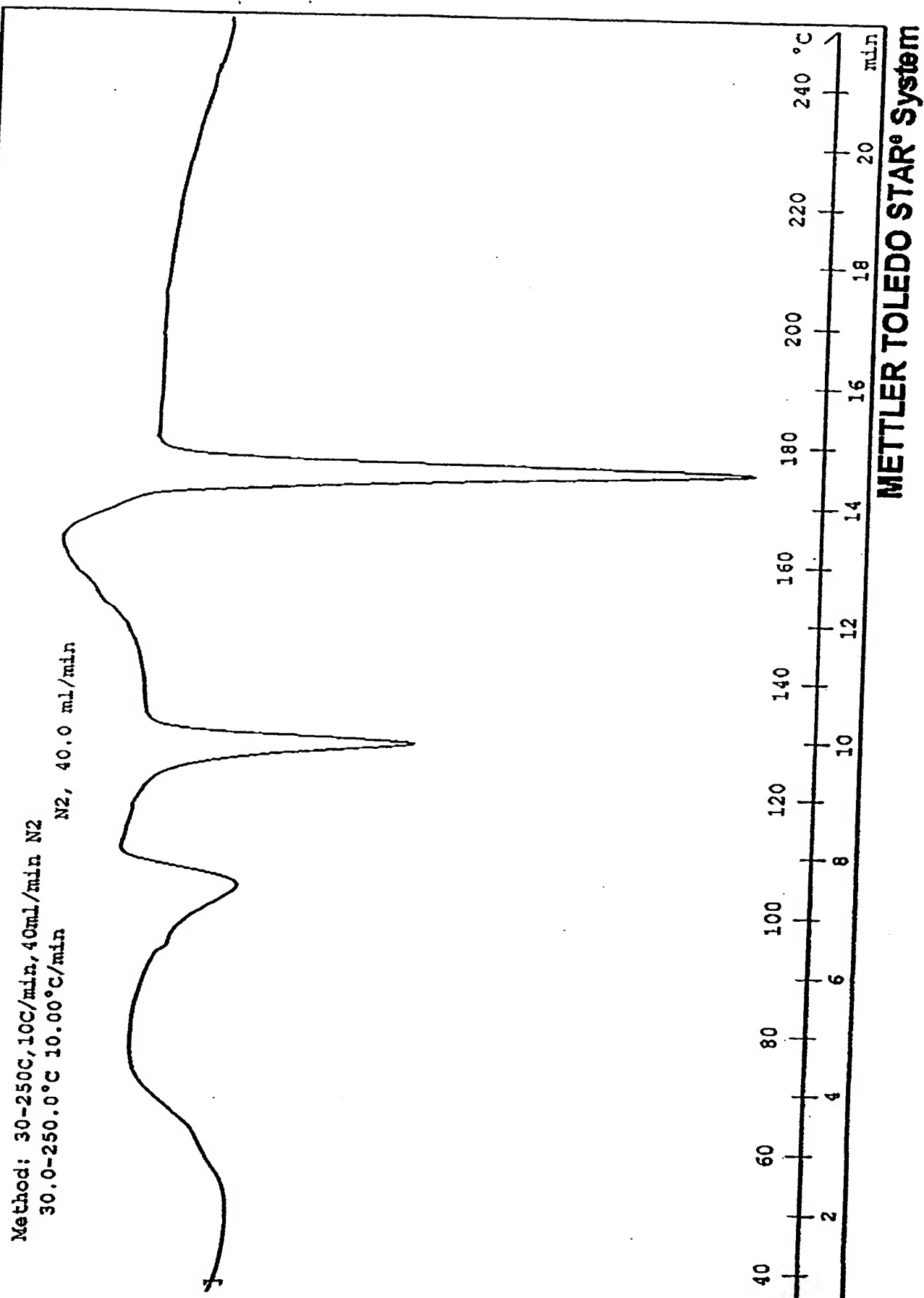
30.0-250.0°C 10.00°C/min

N<sub>2</sub>, 40.0 ml/min



METTLER TOLEDO STAR® System

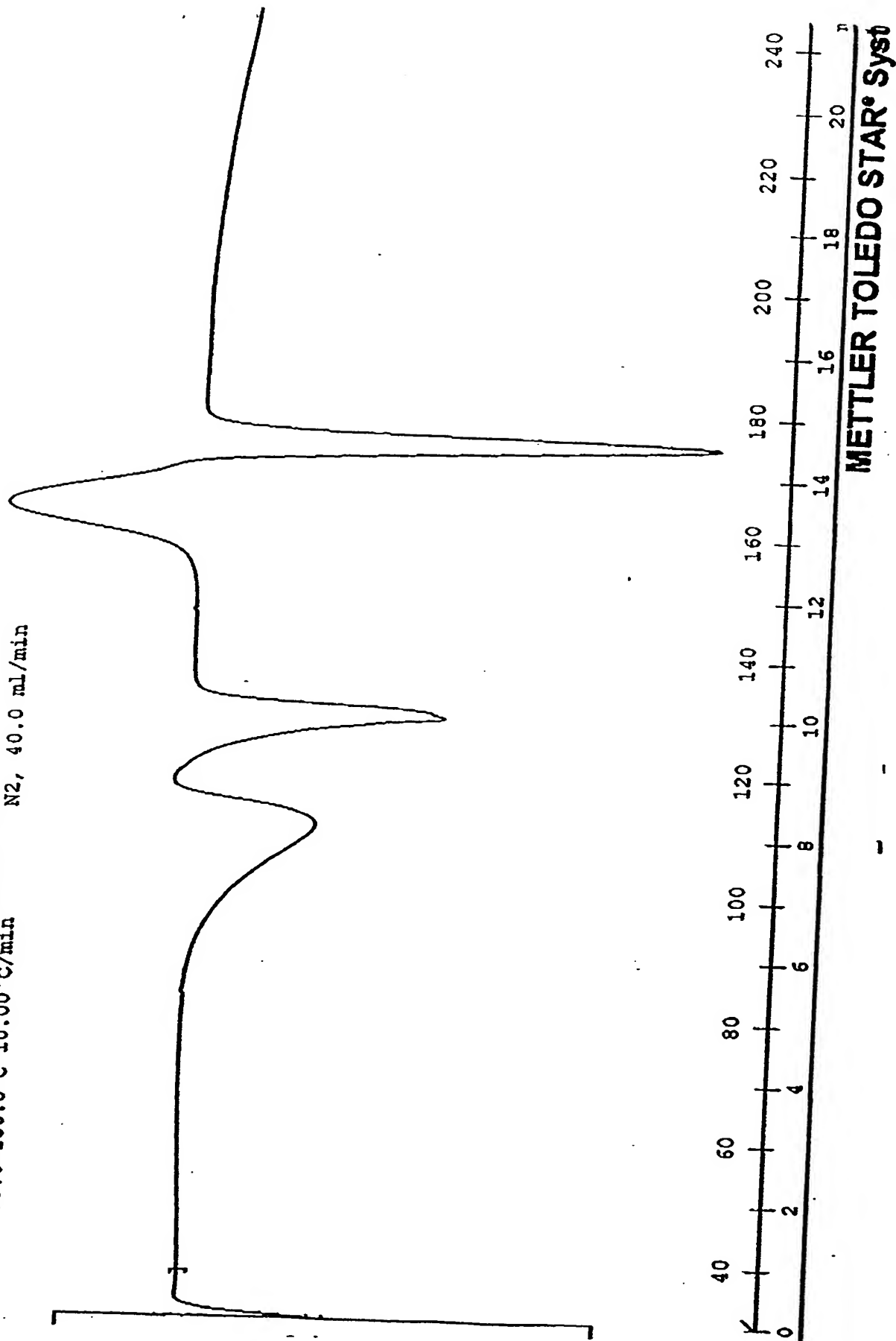
39  
FIGURE 1



40  
FIGURE 33

IXO

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min



METTLER TOLEDO STAR® Syst



FIGURE 2041

Form I

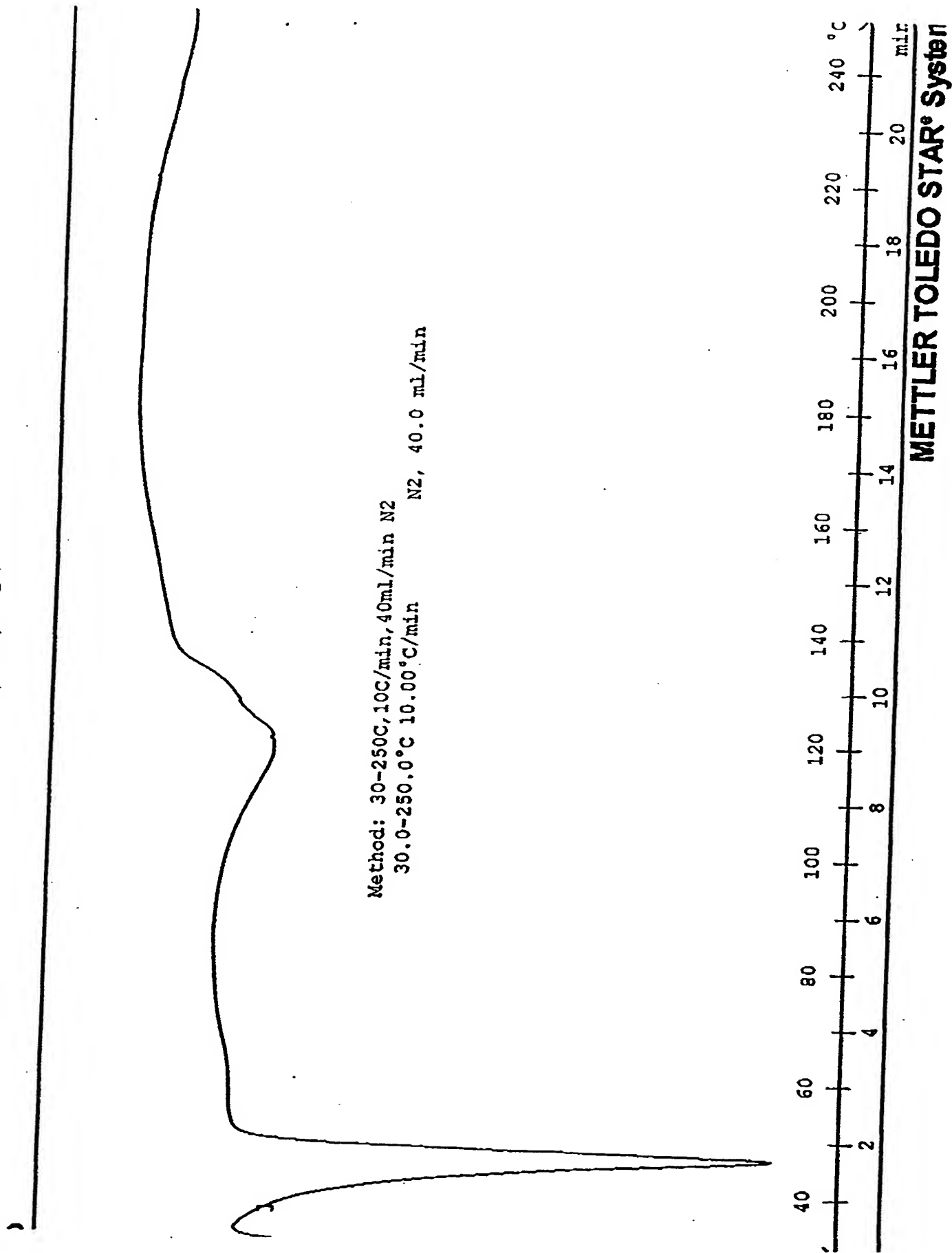


FIGURE 4a  
Form J

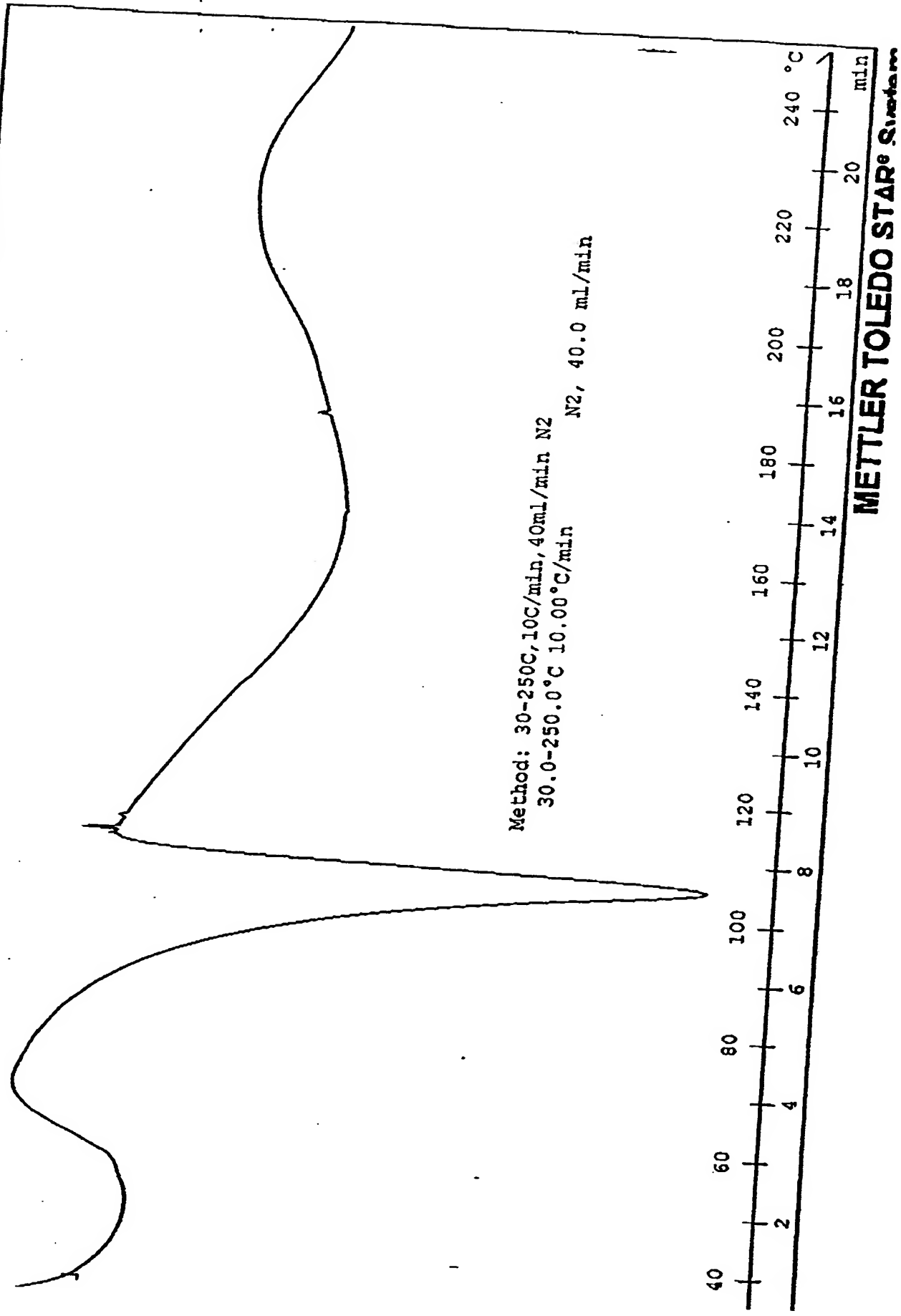
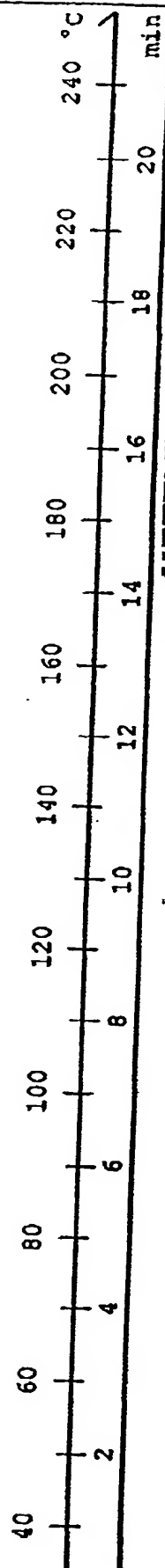


FIGURE 43  
Form K

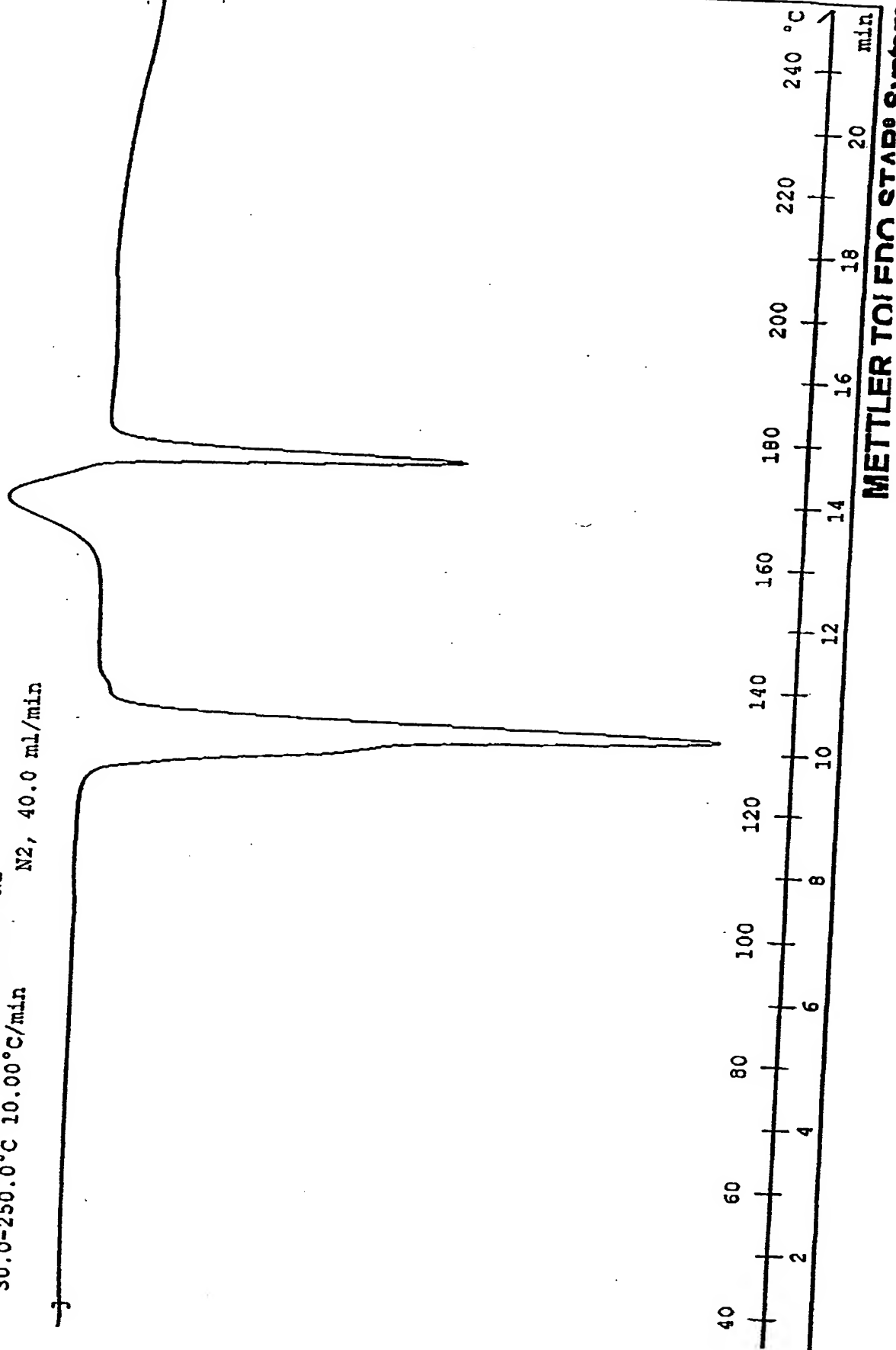
Method: 30-250°C, 10°C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min  
N2, 40.0 ml/min



METTLER TOLEDO STAR® System

FIGURE 42 4/4  
Form L

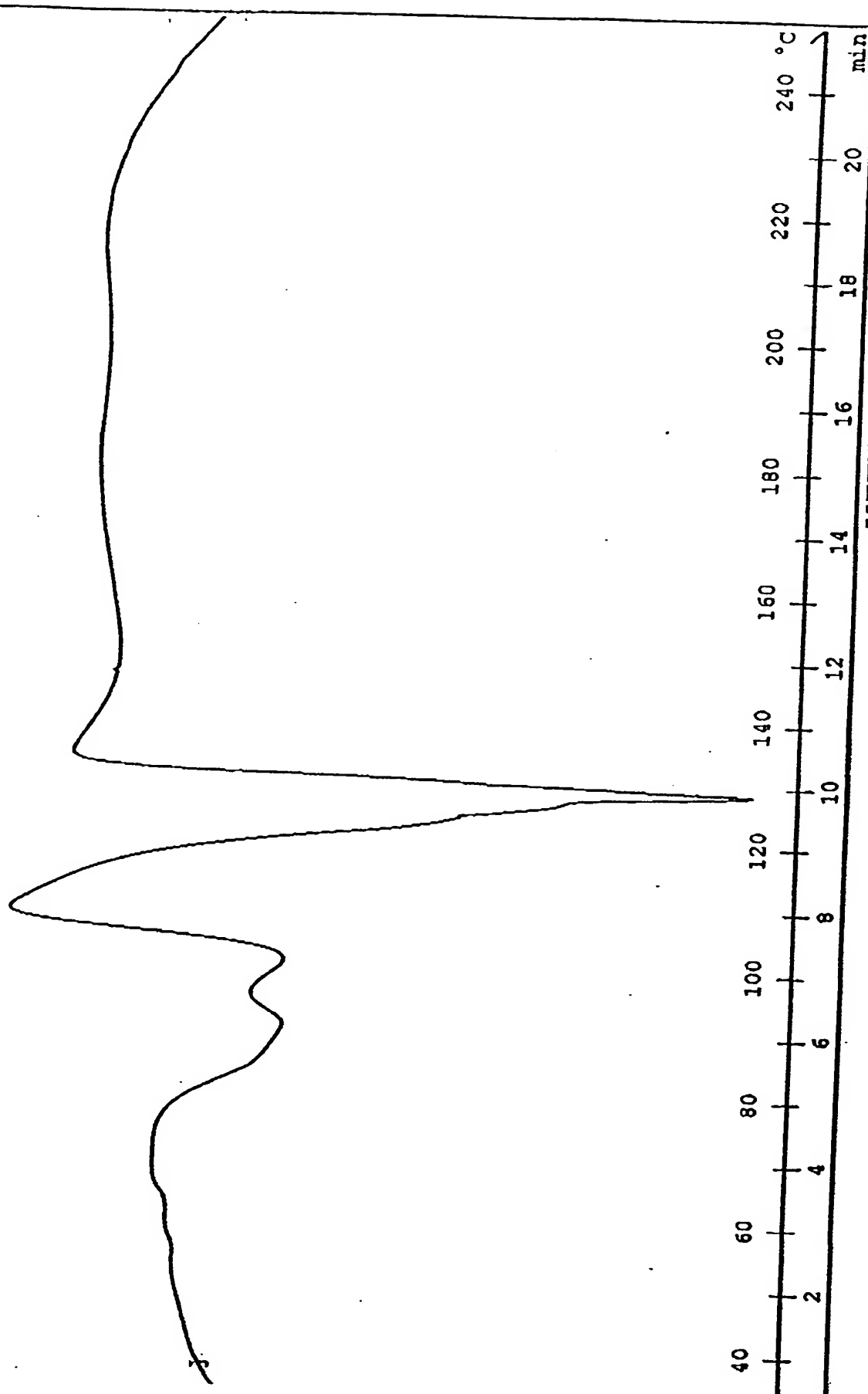
Method: 30-250°C, 10°C/min, 40 ml/min N<sub>2</sub>  
30.0-250.0°C 10.00°C/min N<sub>2</sub>, 40.0 ml/min



METTLER TOLEDO STABO 6.1.1.1

FIGURE 45  
Form M

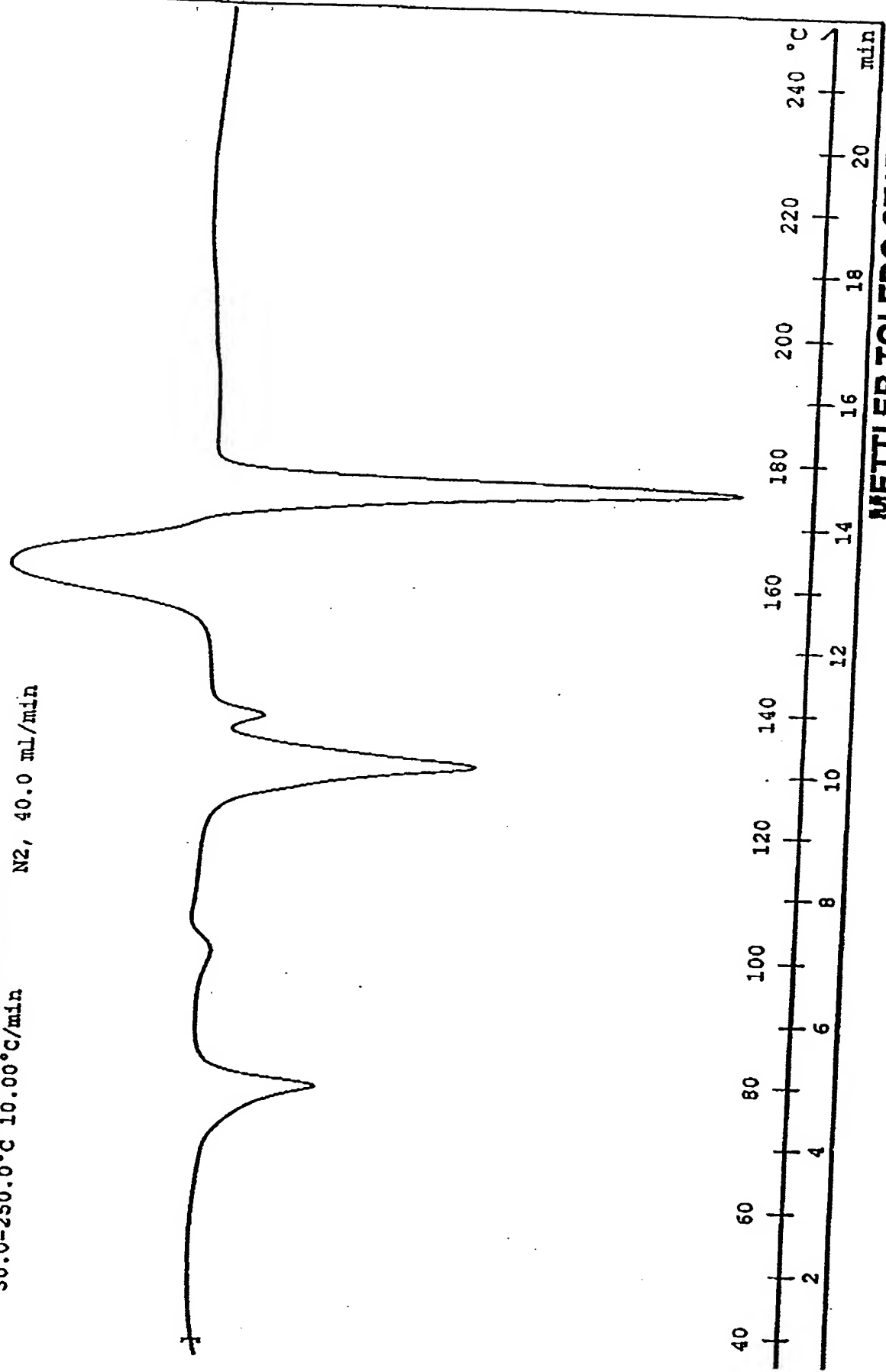
Method: 30-250°C, 10°C/min, 40 ml/min N<sub>2</sub>  
30.0-250.0°C 10.00°C/min N<sub>2</sub>, 40.0 ml/min



METTLER TOLEDO STAR® System

FIGURE 44 46  
Form N

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min

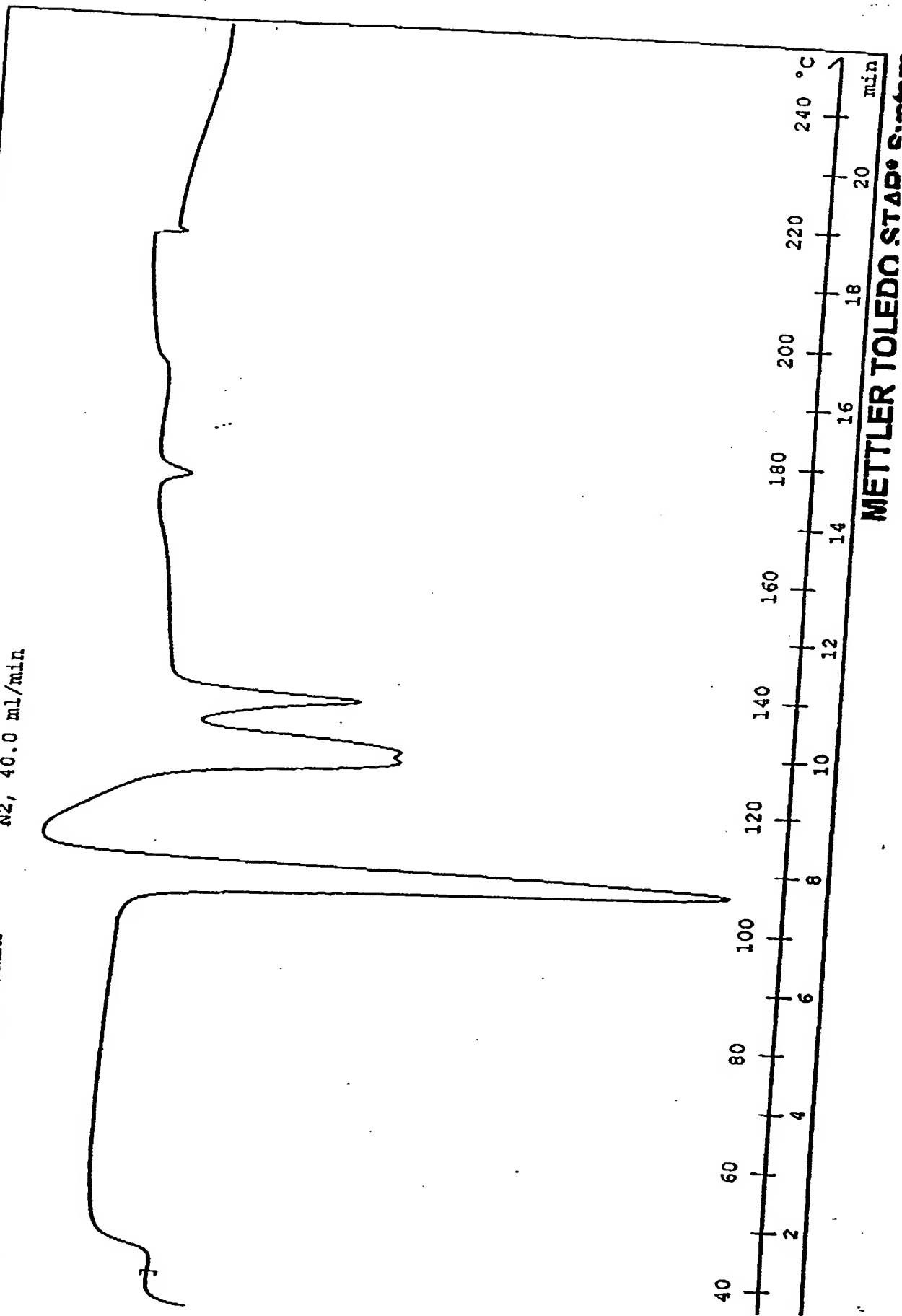


METTLER TOLEDO STAR® System

FIGURE #5 47  
Form G

Method: 30-250°C, 10°C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min

N2, 40.0 ml/min



METTTLER TOLEDO STAD® C.

FIGURE 4.8  
Form P

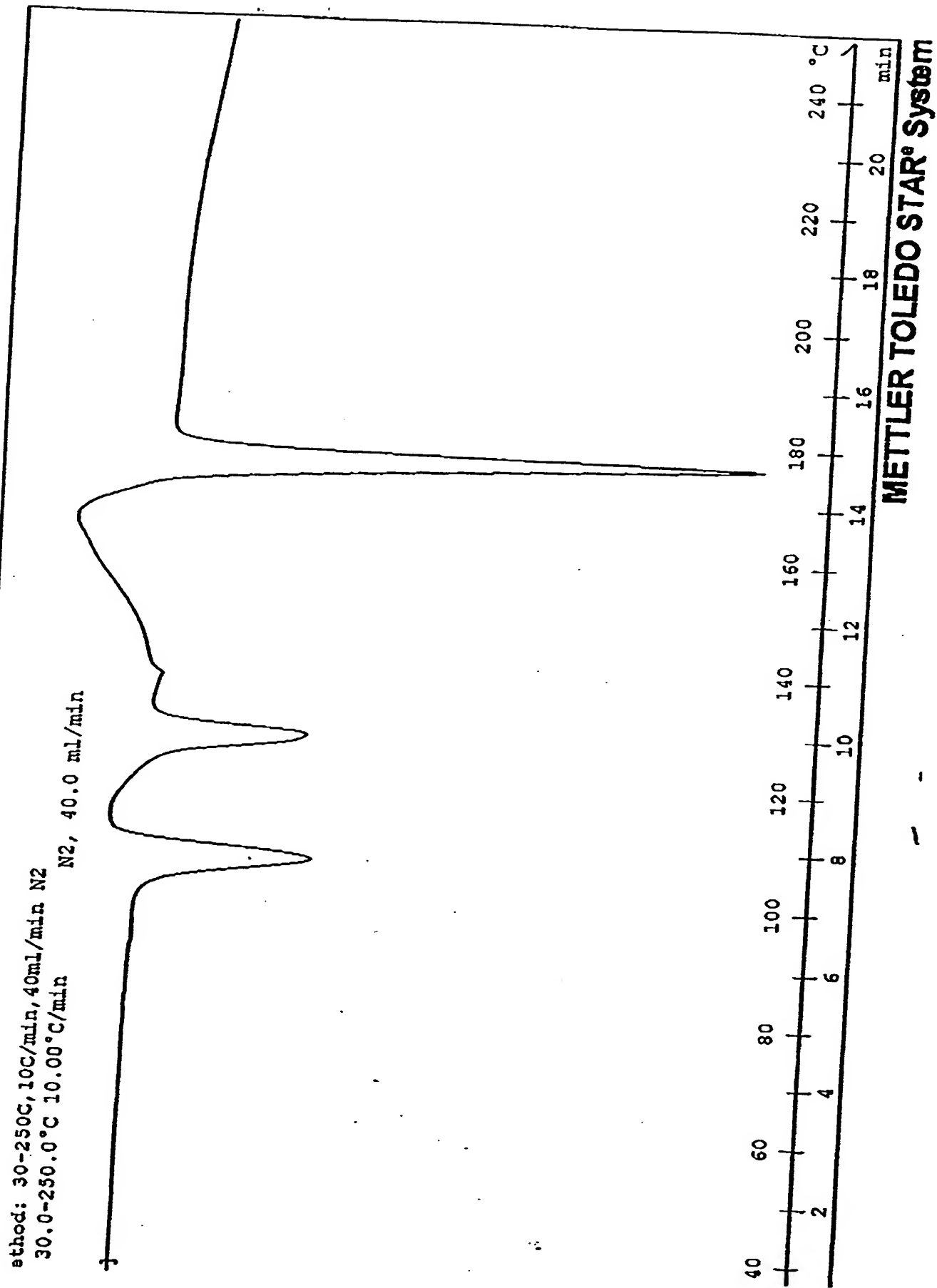
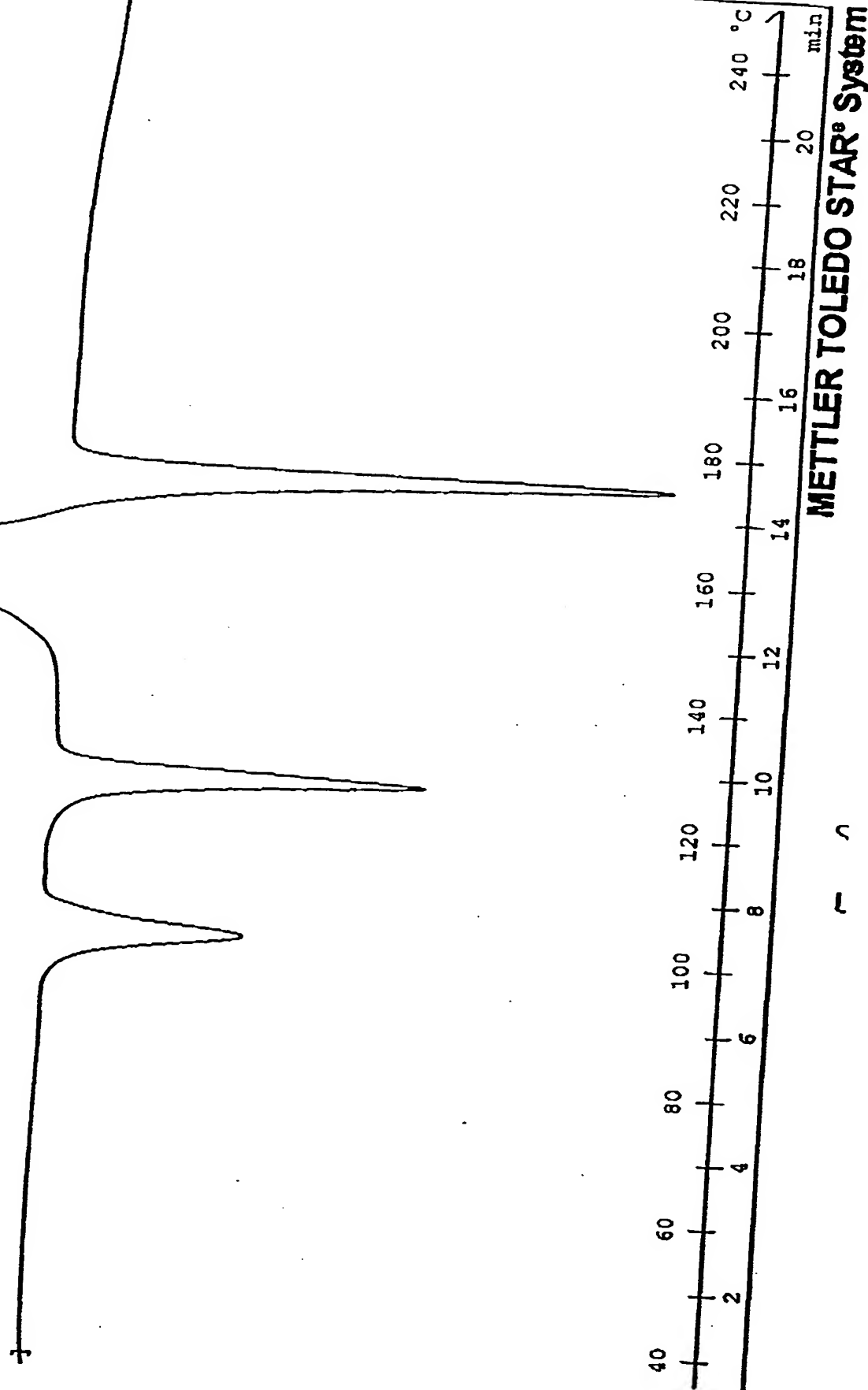




FIGURE 47 49  
Form Q

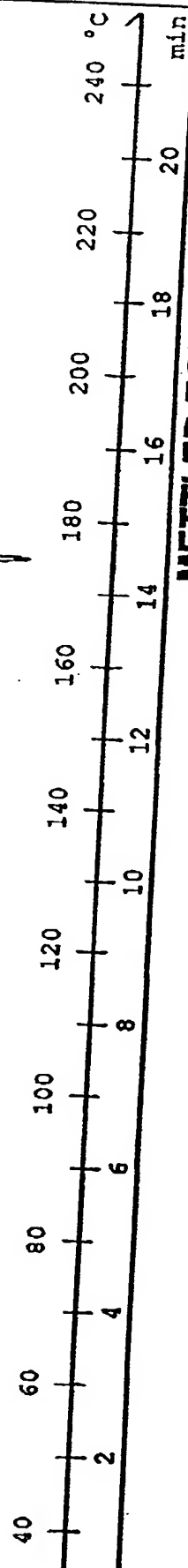
Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min



METTLER TOLEDO STAR® System

FIGURE 48 50  
Form T

Method: 30-250°C, 10°C/min, 40ml/min N<sub>2</sub>  
30.0-250.0°C 10.00°C/min  
N<sub>2</sub>, 40.0 ml/min

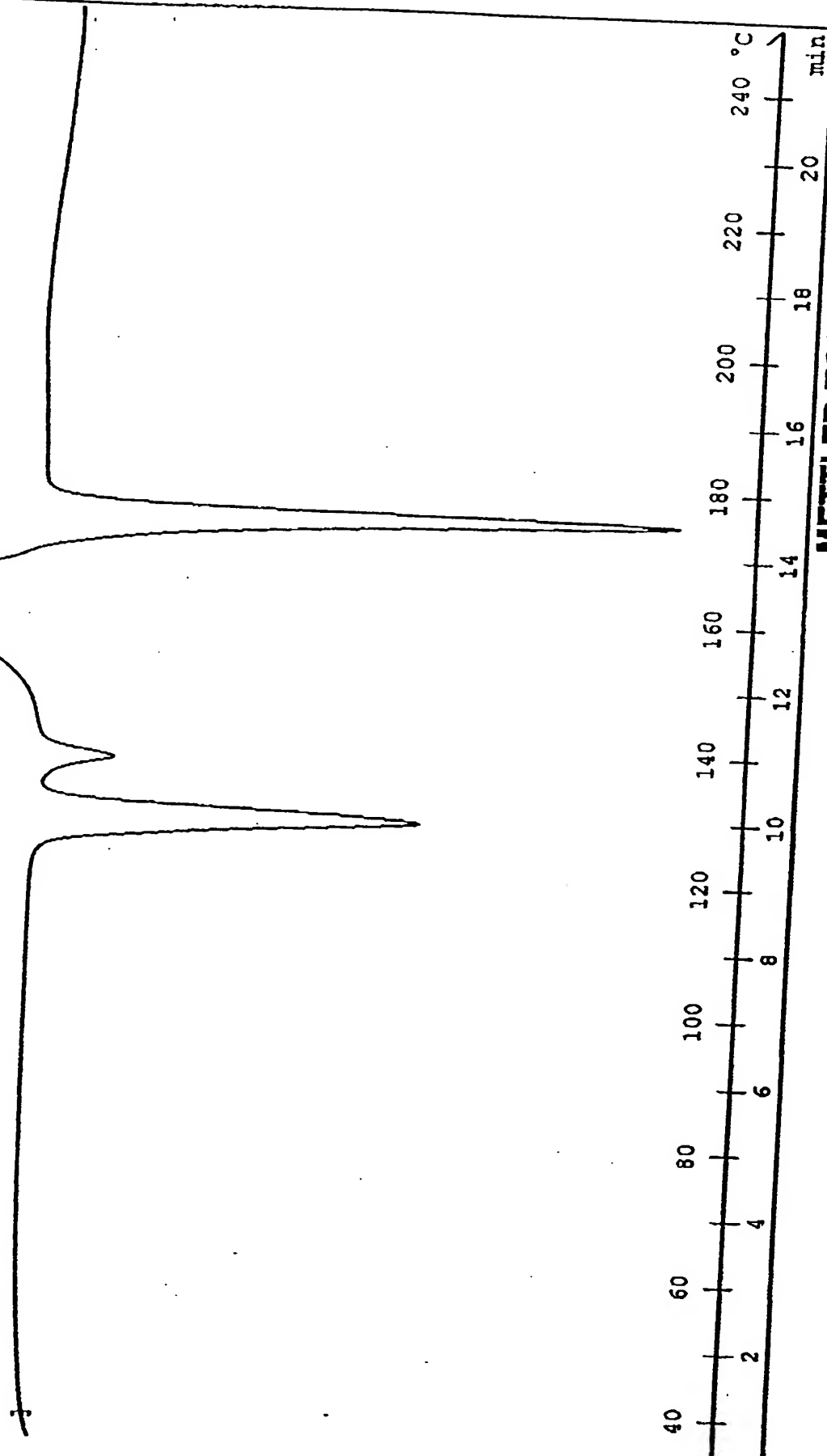


METTLER TOLEDO STAR® System

FIGURE 49. 51

Form 1A

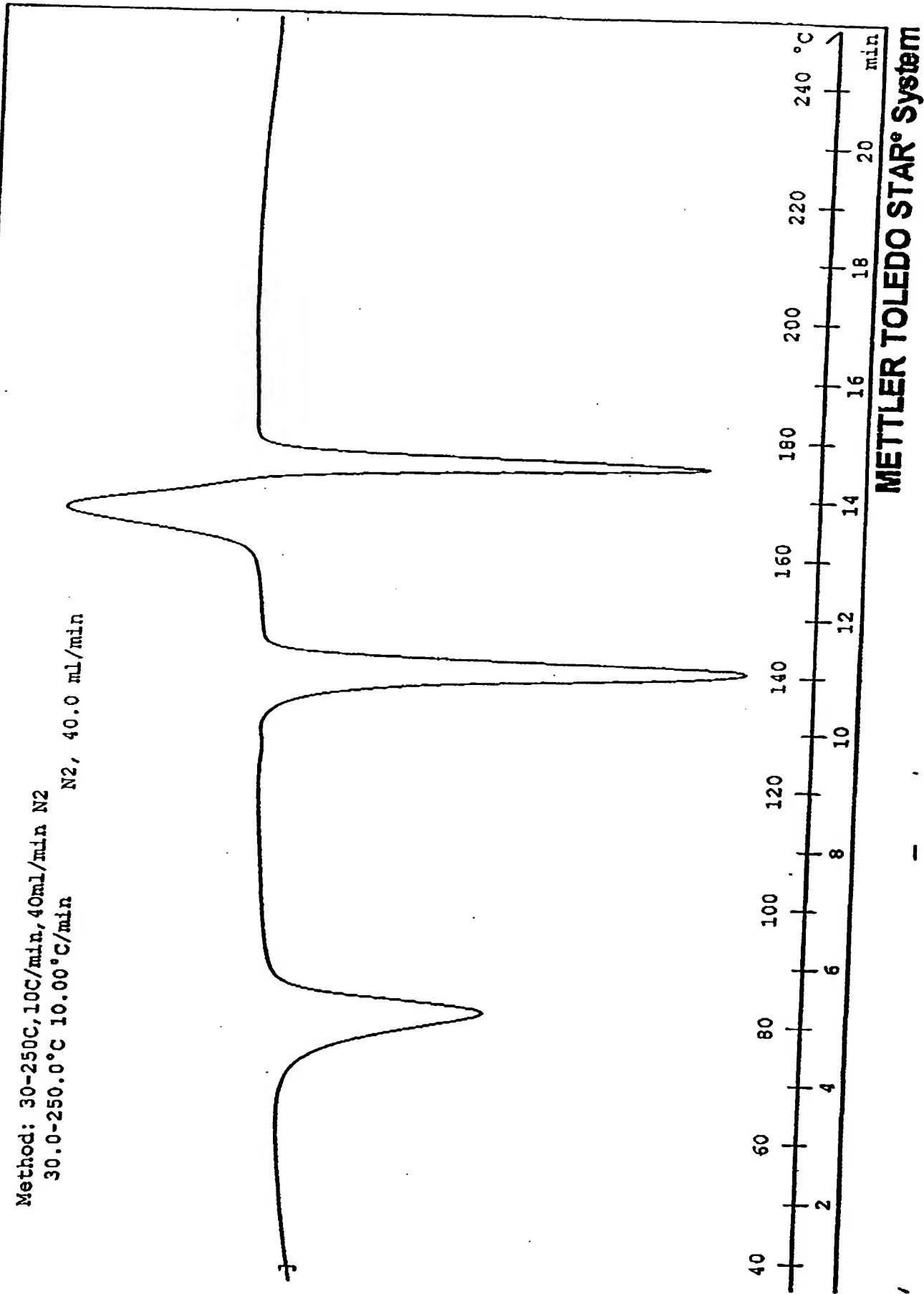
Method: 30-250°C, 10°C/min, 40 ml/min N<sub>2</sub>  
30.0-250.0°C 10.00°C/min N<sub>2</sub>, 40.0 ml/min



METTLER TOLEDO STAR® System

FIGURE 5052  
Form V

Method: 30-250°C, 10°C/min, 40 ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min



METTLER TOLEDO STAR® System

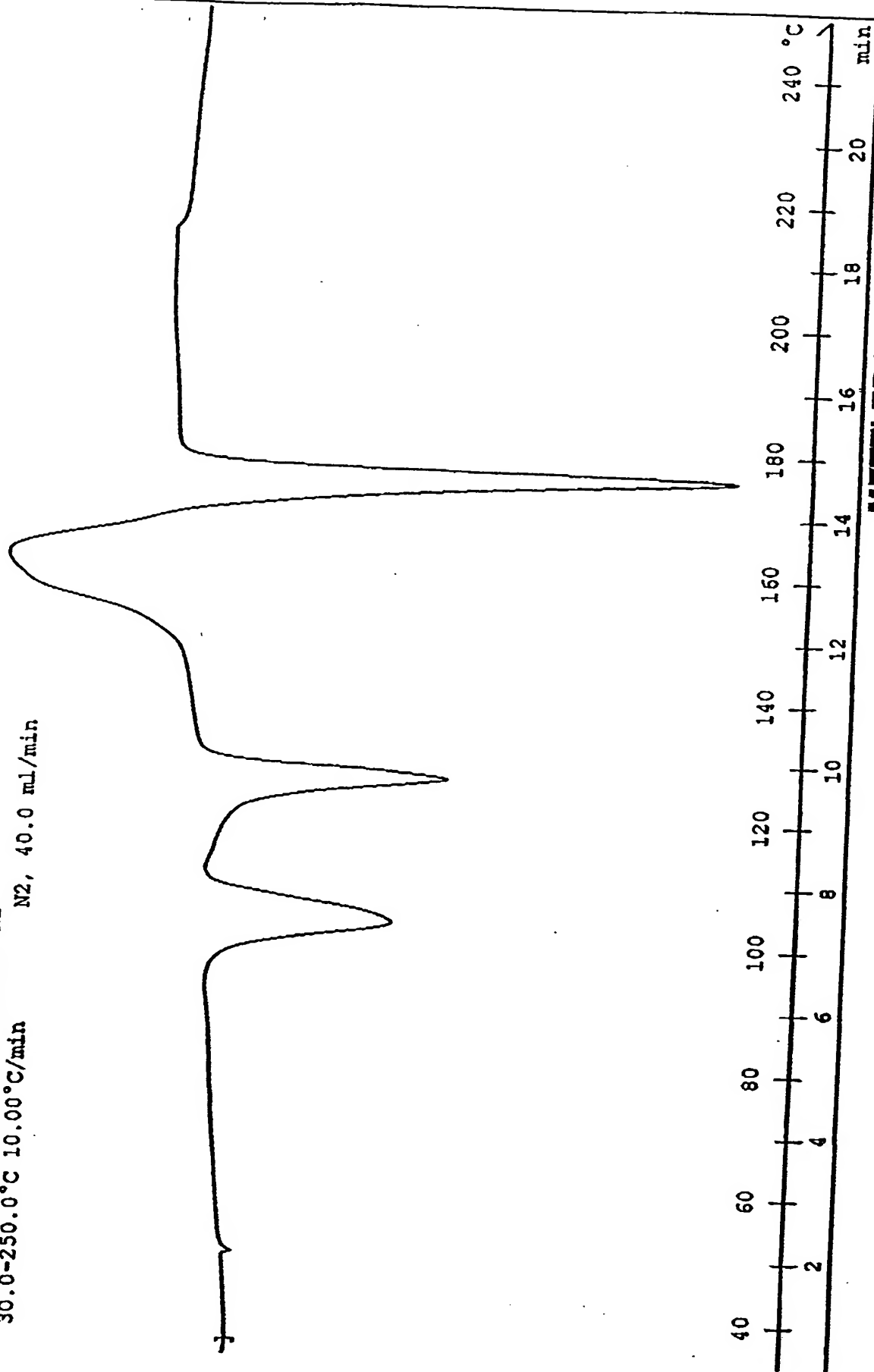
FIGURE 52-53

Fern Y (chloroform solvent)

Method: 30-250°C, 10°C/min, 40ml/min N2

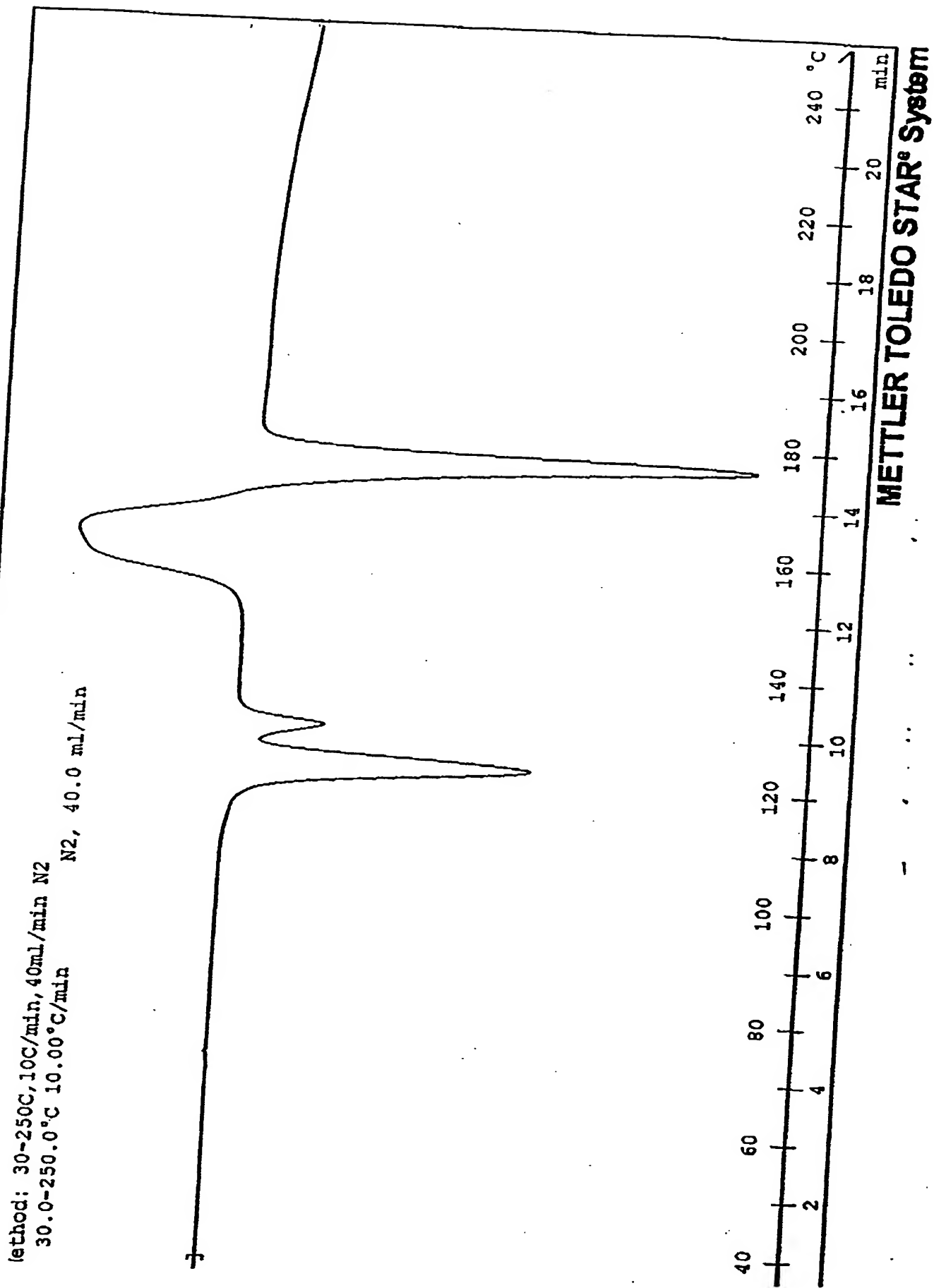
30.0-250.0°C 10.00°C/min

N2, 40.0 ml/min



METTLER TOLEDO STAR® System

FIGURE 5.4  
Y (dichloromethane solvent)



55  
Figure 27 - Nataglinde Form Z

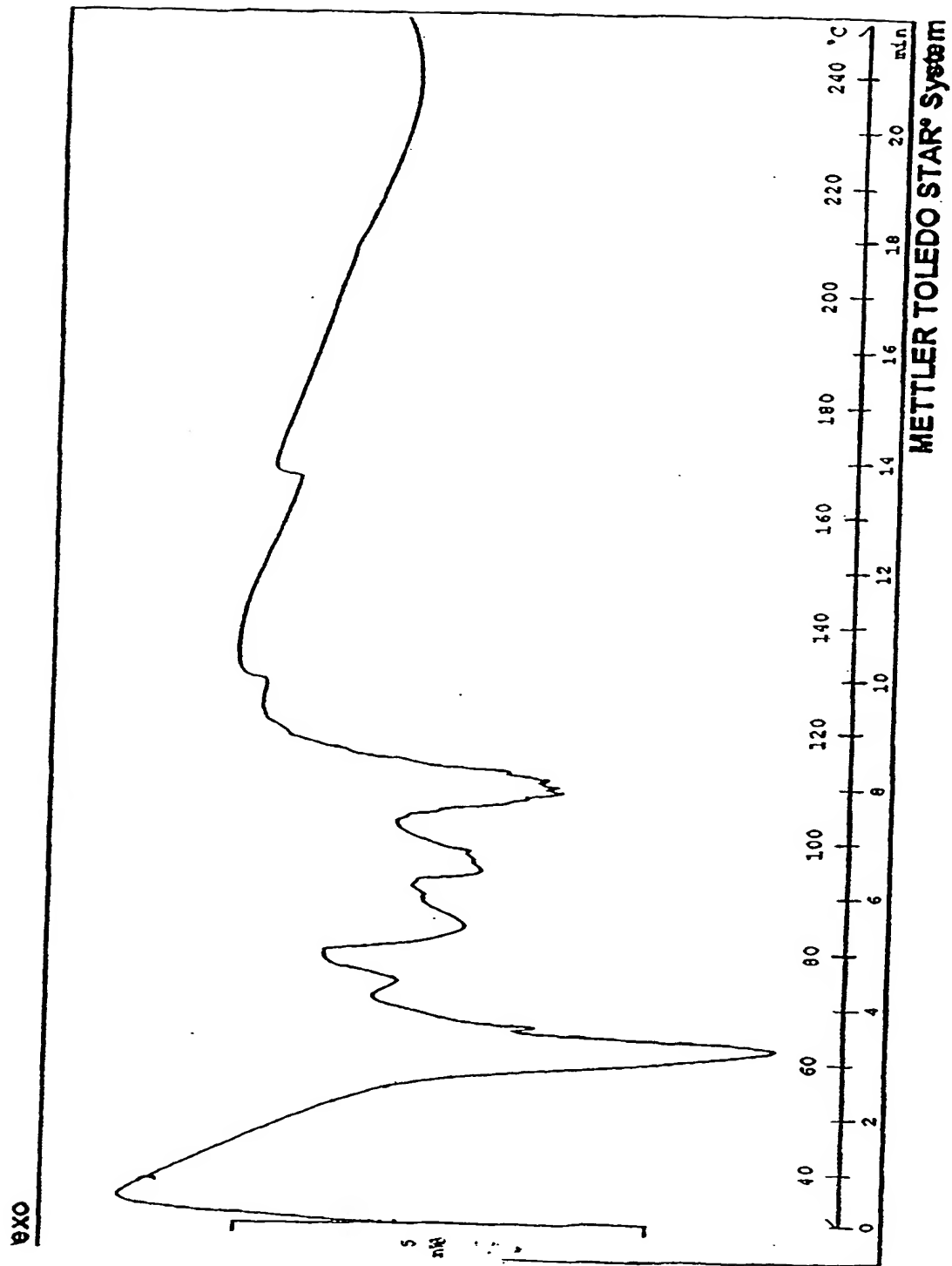
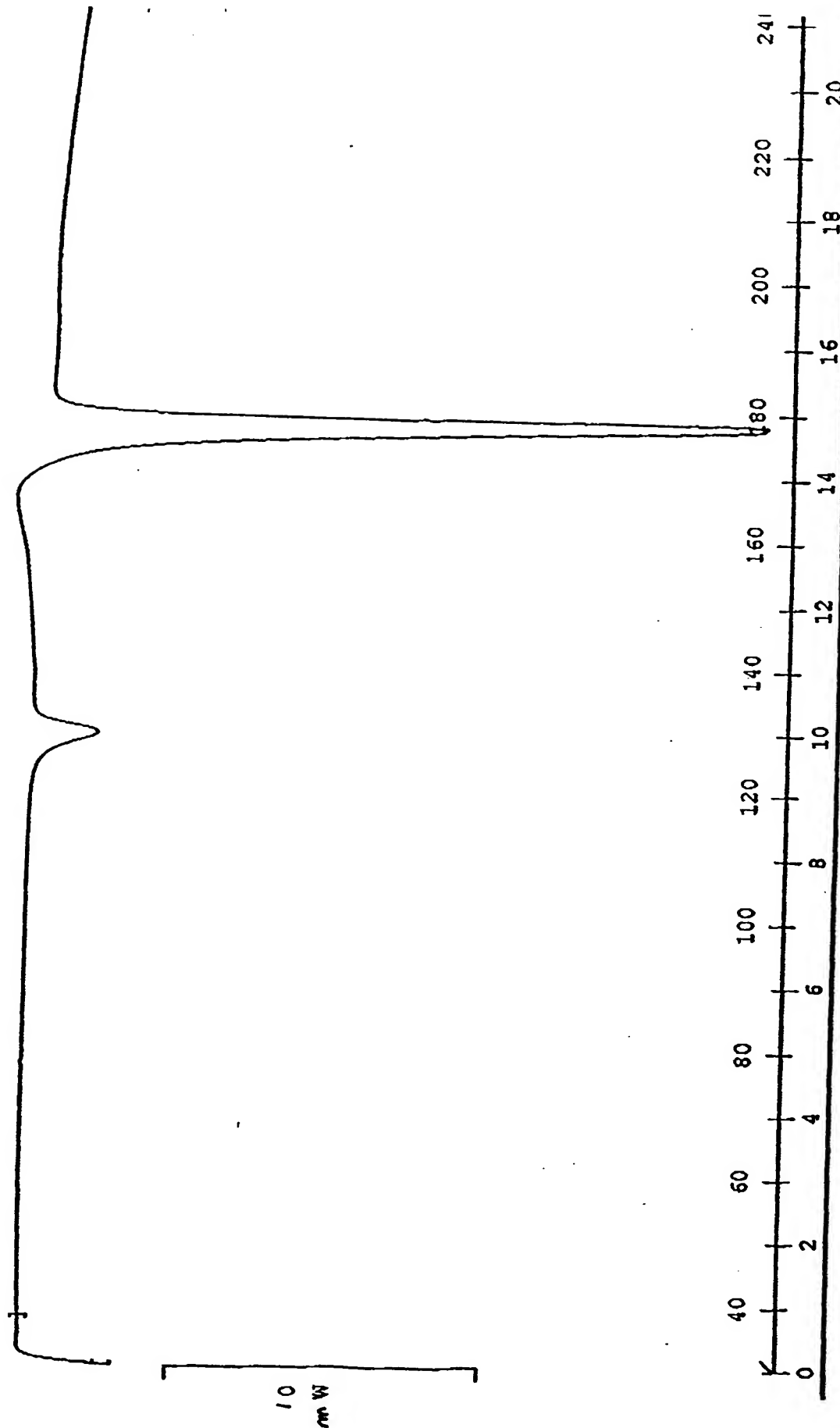


FIGURE 51-56  
Form  $\alpha$

IXO

Method: 30-250°C, 10°C/min, 40ml/min N<sub>2</sub>  
30.0-250.0°C 10.00°C/min N<sub>2</sub>, 40.0 ml/min

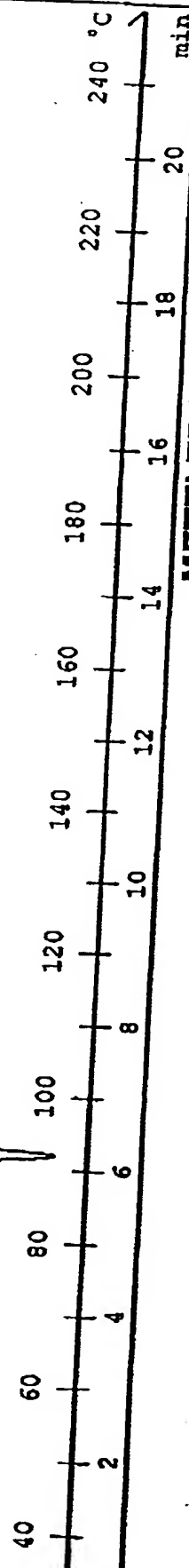


METTLER TOLEDO STAR<sup>®</sup> SW



FLUKE 57  
Form Beta

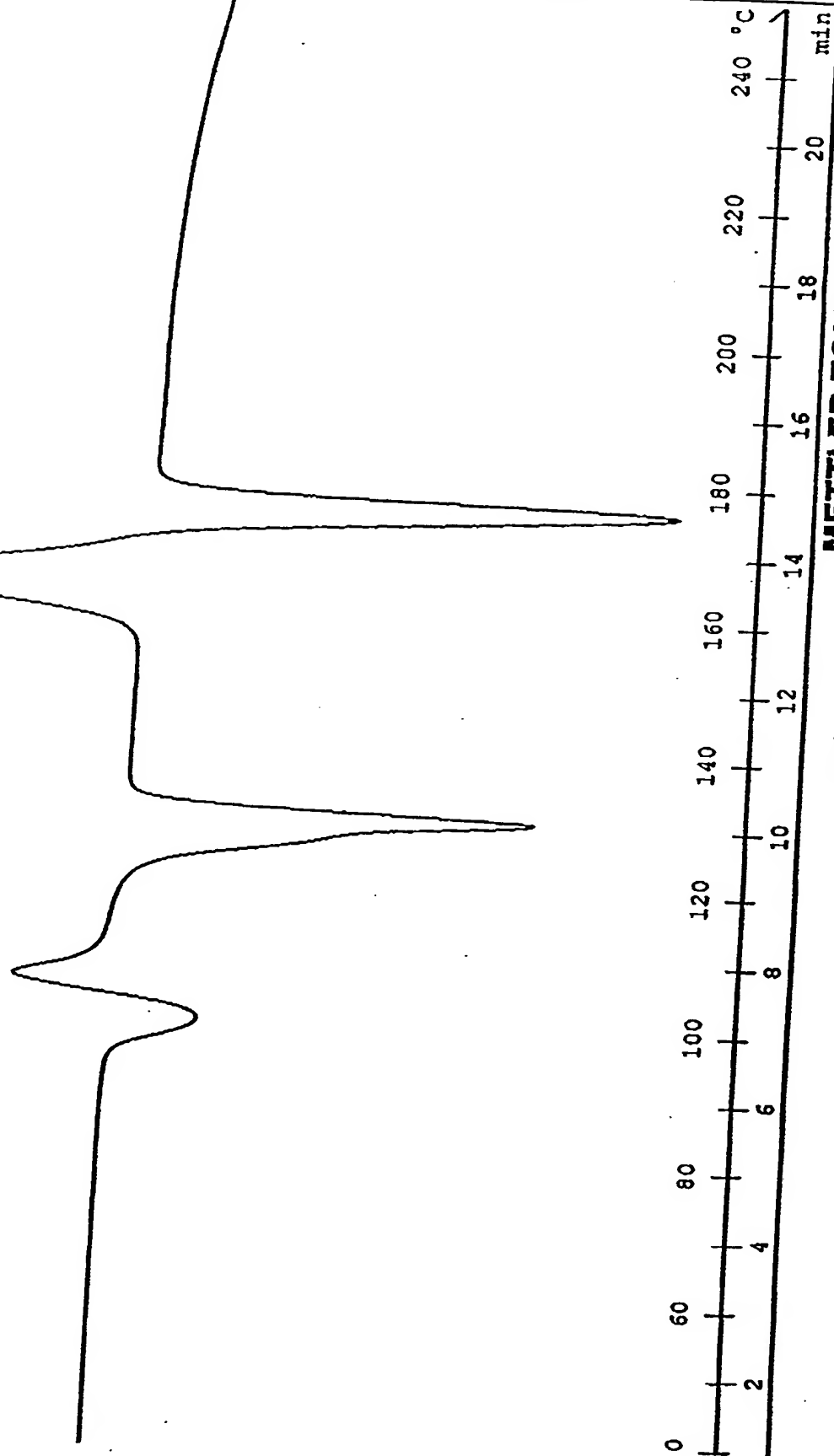
Method: 30-250°C, 10°C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min  
N2, 40.0 ml/min



METTLER TOLEDO STAR® System

FIGURE 55-58  
Form Delta

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min



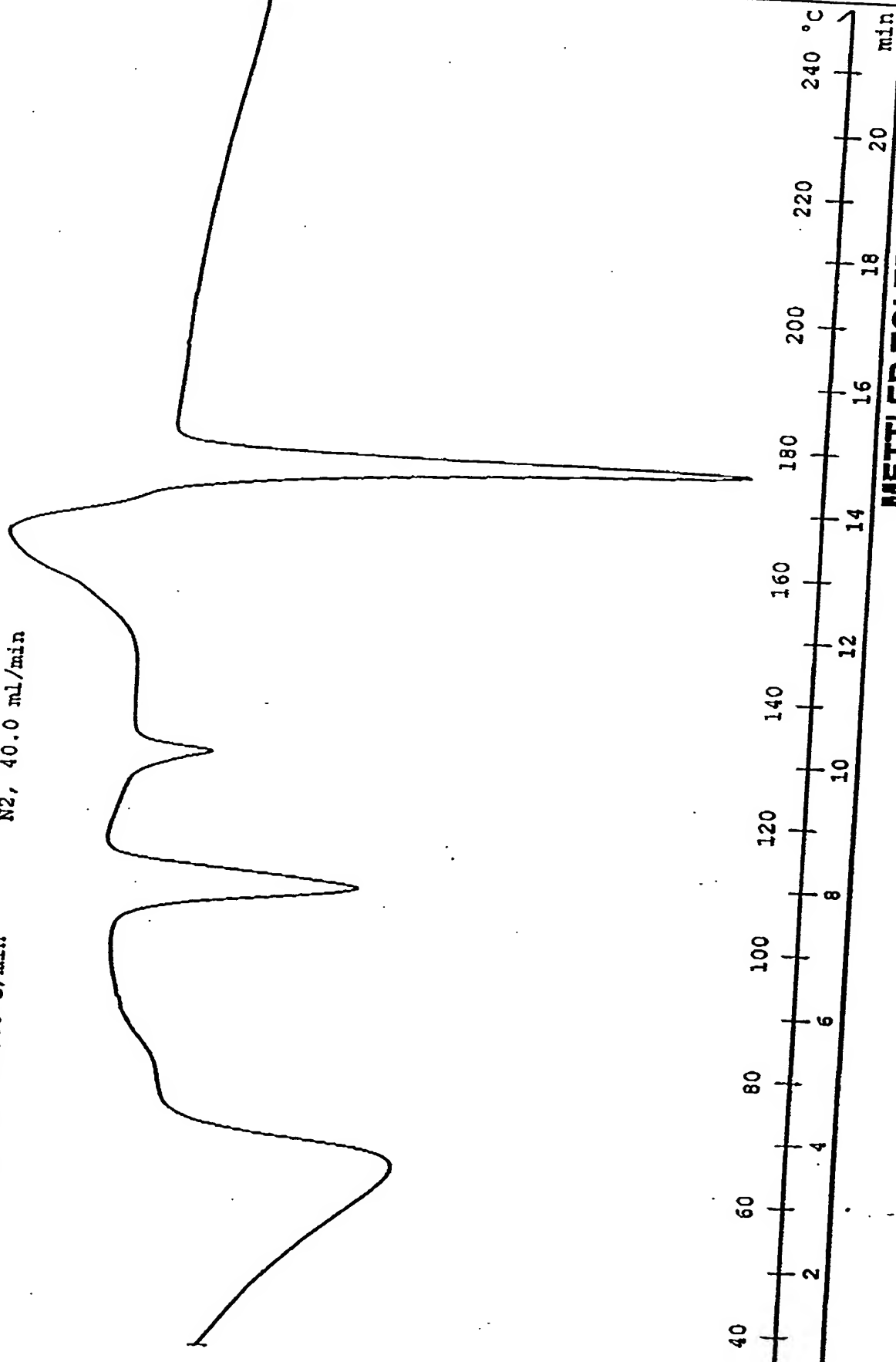
METTLE TOLEDO STAR° System

- Delta

Form Epsilon 59

FIGURE 56

Method: 30-250°C, 10°C/min, 40 ml/min N2  
30.0-250.0°C 10.00°C/min  
N2, 40.0 ml/min



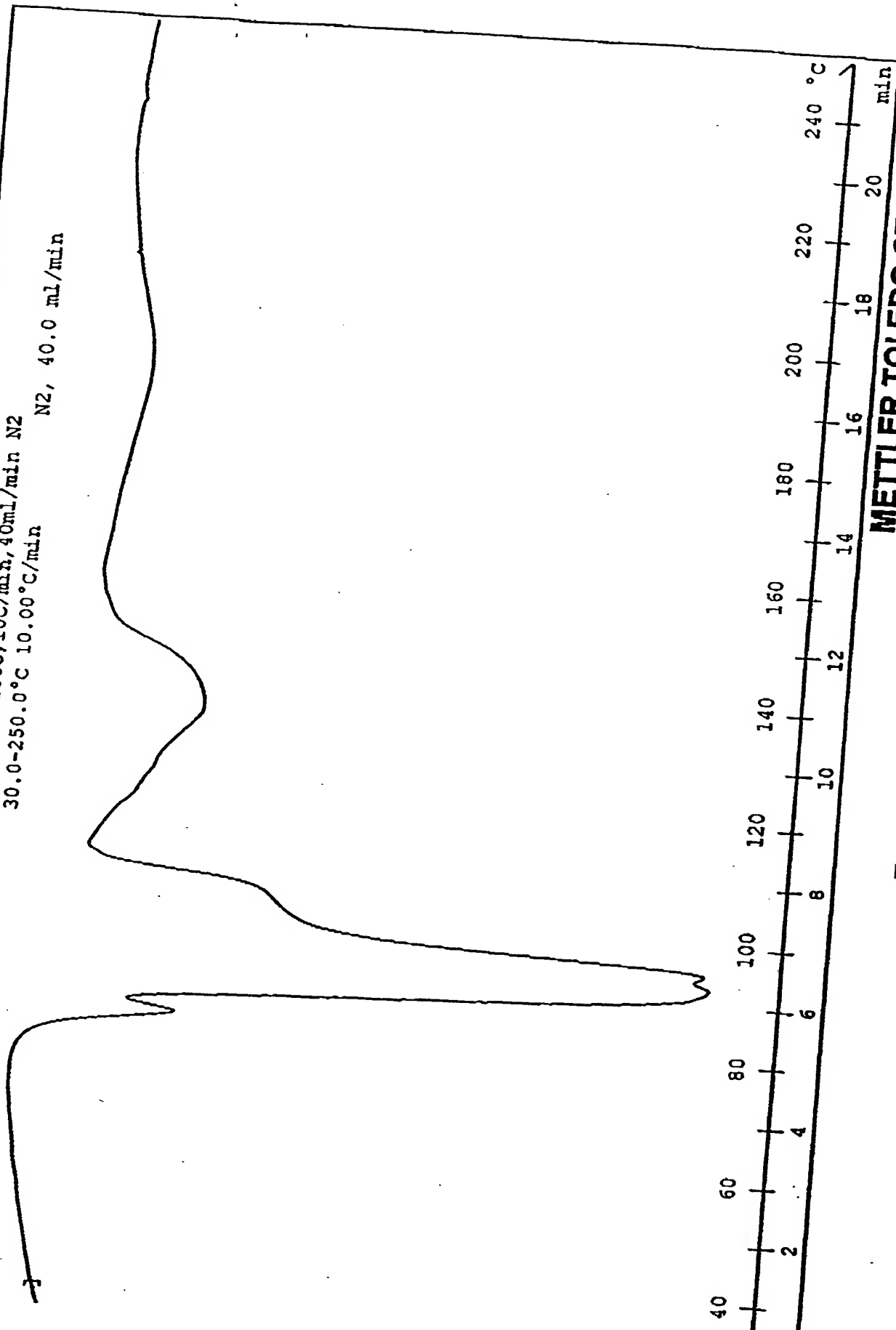
METTLER TOLEDO STAR® System

FIGURE 57  
60

Form ~~P~~ Gamma

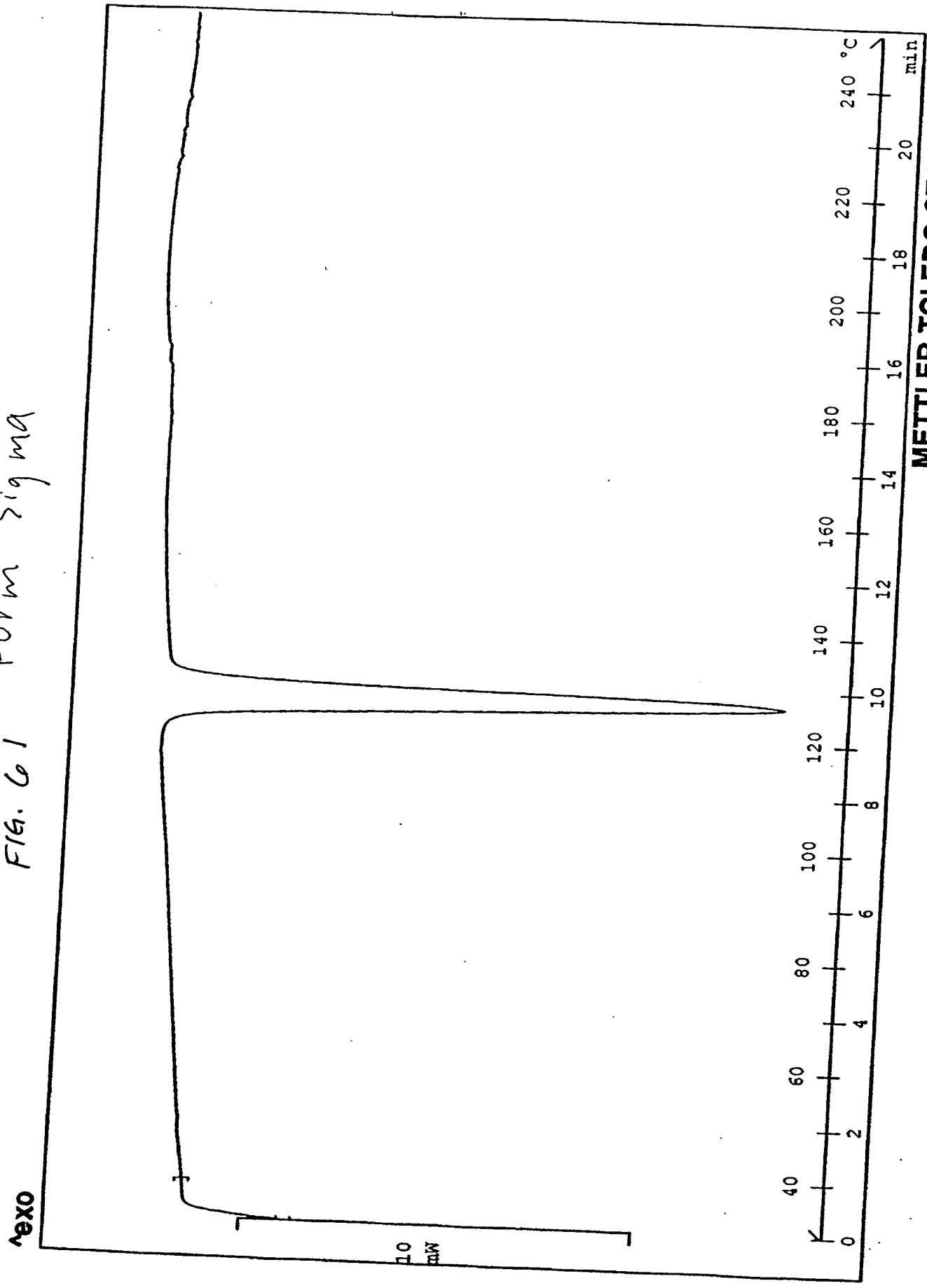
Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min

N2, 40.0 ml/min



METTLER TOLEDO STAR® System

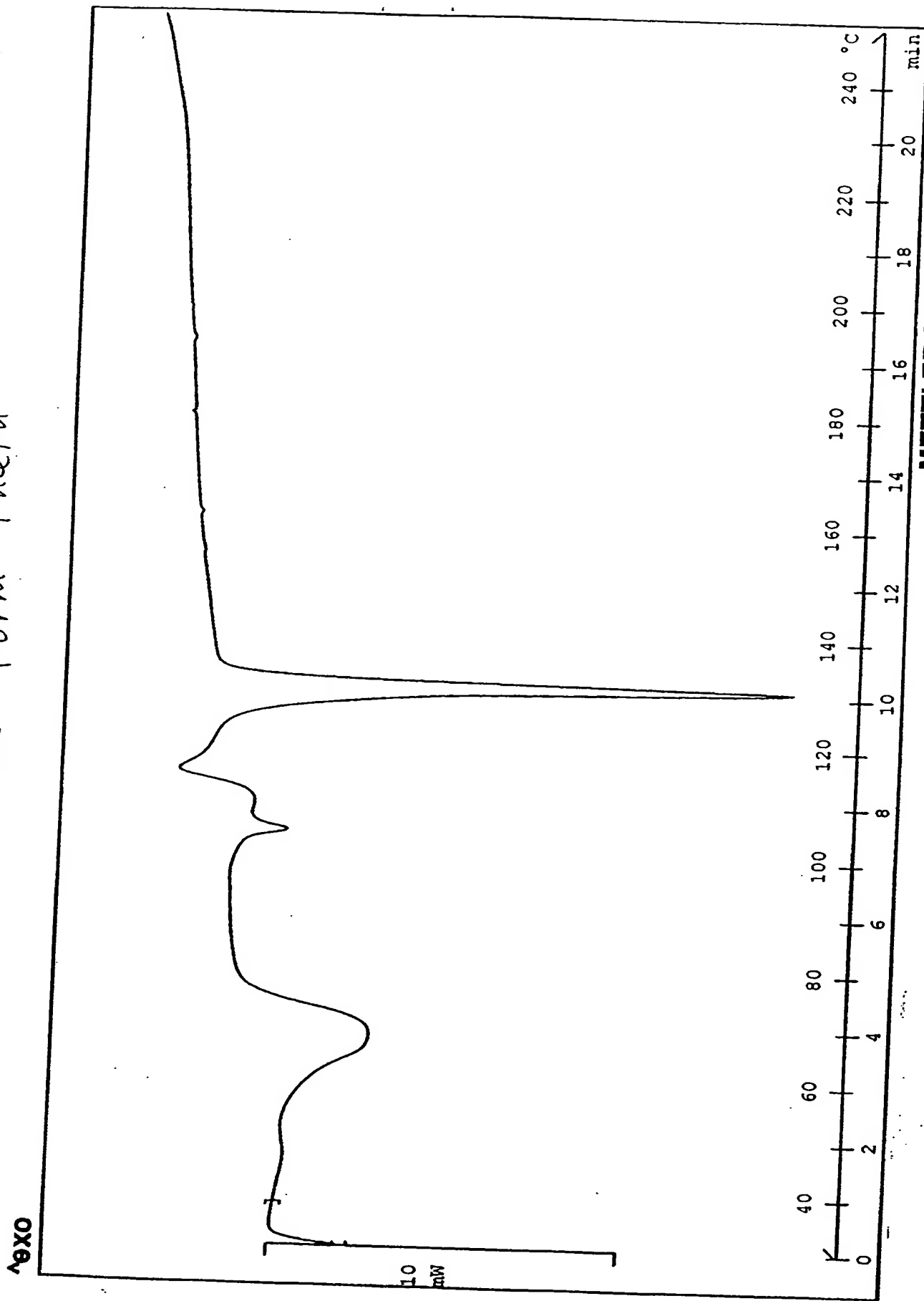
FIG. 61 Form Sigma



METTTLER TOLEDO STAR® System

Form  $\sigma$  (Q)

FIGURE 62 Form Theta



METTLER TOLEDO STAR<sup>®</sup> System

Form  $\theta$

Figure 63

Omega wet

Step.: 0.050° Cnt Time: 0.600 Sec.  
Range: 2.00 - 30.00 (Deg) Cont. Scan Rate : 5.00 Deg/min.

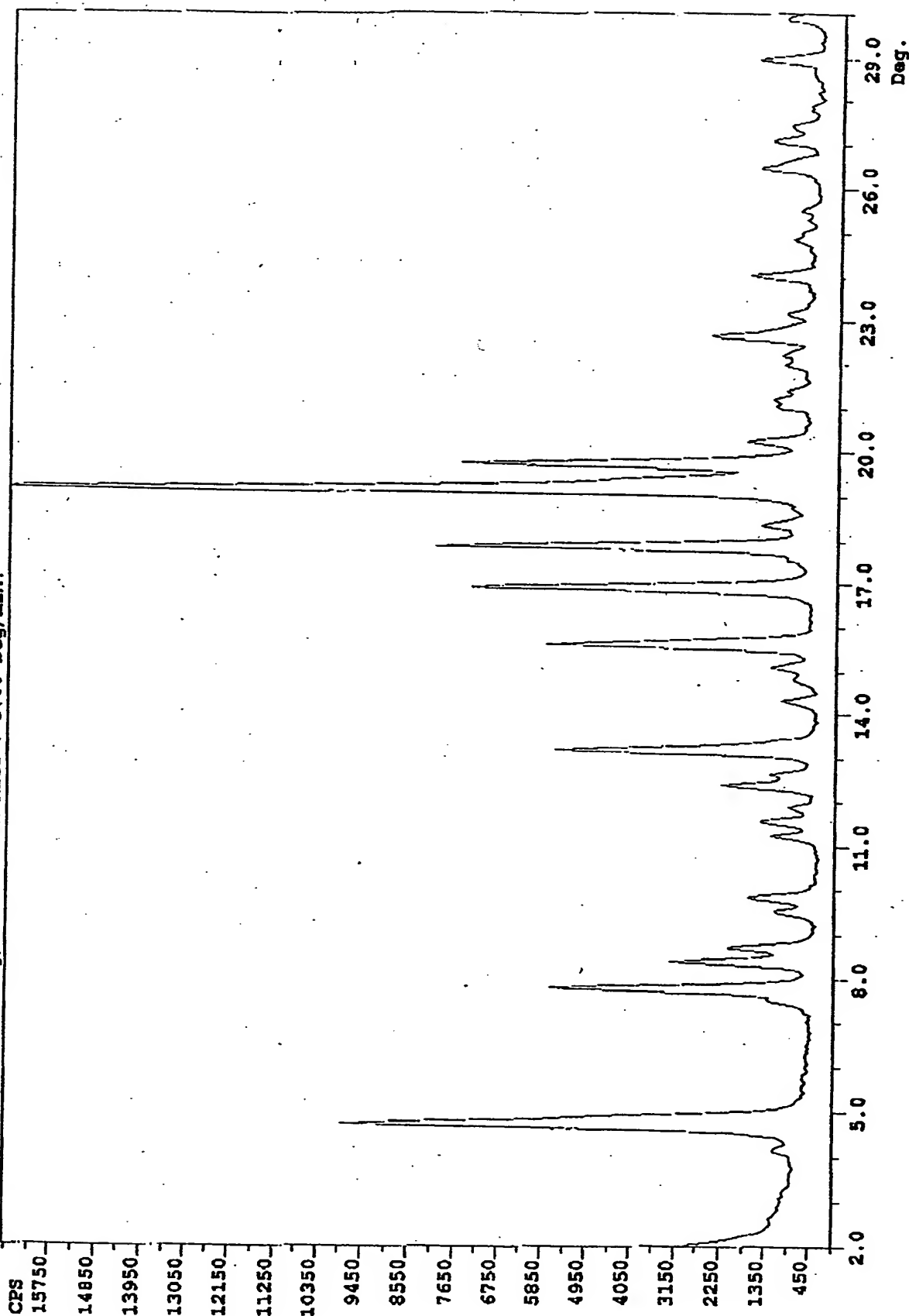


Figure 64

Comparison between the impurity profile of Nateglinide crystallized in IPA-H<sub>2</sub>O and Nateglinide crystallized in Methanol-H<sub>2</sub>O

Sample No	Solvent	Impurity profile by RRT [% w/w]						
		D-PA (0.23)	(0.25)	(0.46)	(0.80)	Ipcha (0.89)	Dimer (1.38)	Methyl Ester (1.51)
RL-2155/1	Methanol-H <sub>2</sub> O	<0.01		0.02	<0.01	0.03	0.02	2.91
RL-2163/4	IPA-H <sub>2</sub> O	<0.01	0.04		0.02	0.02	0.01	0.04
								0.03
								0.02

Note: D-PA means D-Phenyl Alanine

Ipcha means Iso propyl cyclohexyl carboxylic acid

Both are the starting materials of the product

(-)-N-[(trans-4-isopropyl cyclohexane)carbonyl]-D-phenylalanine



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